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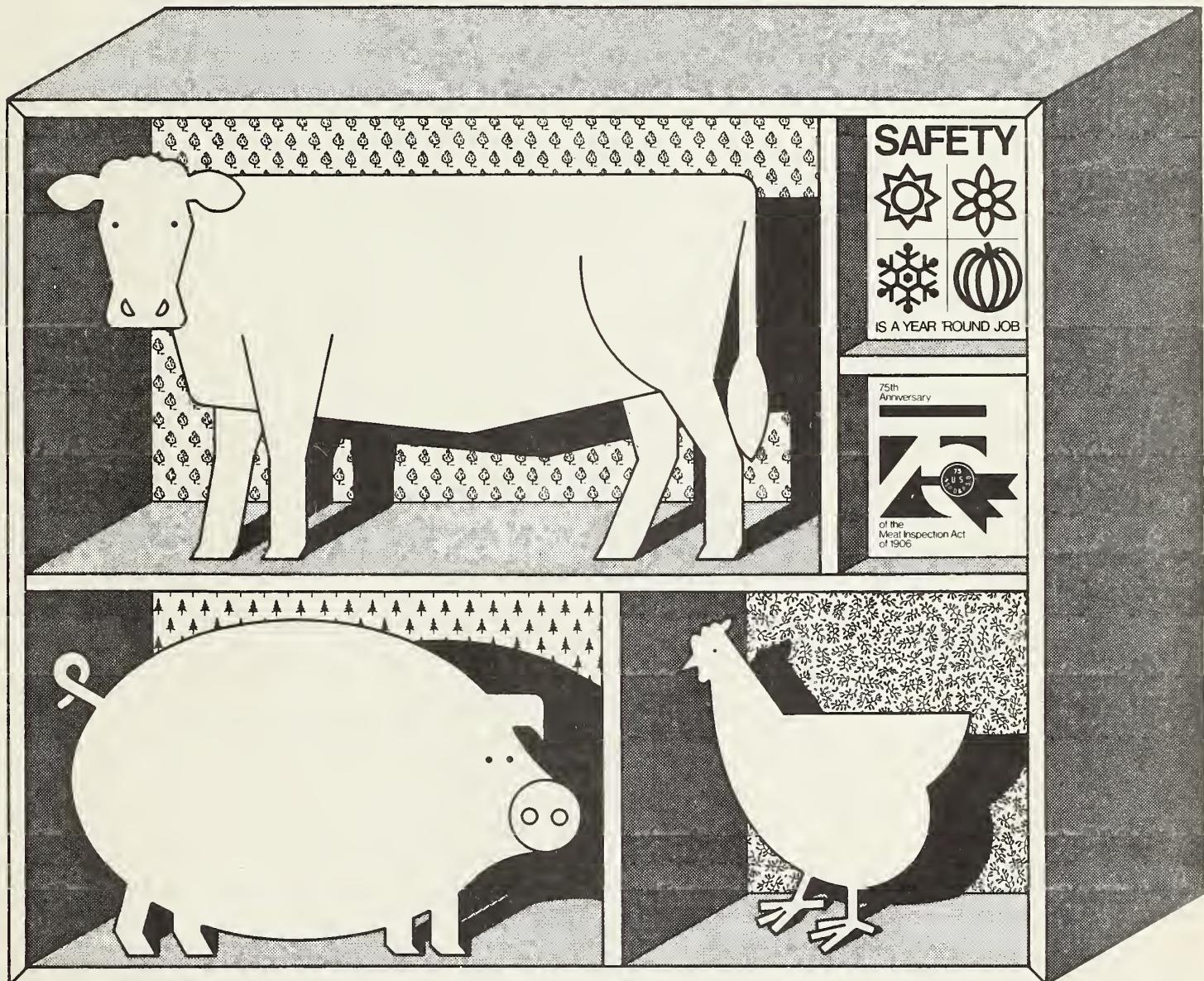
Meat and Poultry  
Inspection  
Program

December 1982

# INDIA Issuances of the Meat and Poultry Inspection Program

FEB 7 '83

Centralized Animal Health Services



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UNITED STATES DEPARTMENT OF AGRICULTURE  
Food Safety and Inspection Service  
Meat and Poultry Inspection Operations  
Washington, DC 20250

MPI BULLETIN 82-63-A  
11-30-82

INFORMATION FOR: MPI Employees and Interested Parties

CHECKLIST OF MPI BULLETINS

This checklist includes active bulletins published on or before November 30, 1982, and obsolete bulletins canceled August 31, 1982, through November 30, 1982. Bulletins not appearing on this list (except those published after November 30, 1982) are obsolete and should be removed from active files.

NUMBER/ DATE	SUBJECT	ORIG. STAFF CATEGORY DIST. CODES
11 6/23/72	Plant Operating Schedules Working Conditions, Poultry Plants	FO/A S-12, S-13, ES-14, S-15, ES-16 ES-16, ES-16-1, ES-16-2, S-17, S-18 (Poultry Plants)
211 2/20/73	New Weight Compliance	PLS/G Q
263 4/6/73	Waste Disposal Permit	FO/B P, Q, U-2
367 8/1/73	Meat Trimmings	PLS/H Q, P, T, U U-2
388 8/10/73	Meat Trimmings	PLS/H Q, P, T, U
392 8/10/73	Cured Meat Product Labeling	PLS/F Q, P, T, U-U-2

DISTRIBUTION: Issuances	CATEGORY: A, GENERAL	OPI: REGULATIONS OFFICE
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418 8/31/73	Labeling Standards for Certain Cooked Sausages	PLS/F Q,P,T,U-U-2
456 10/19/73	Warm Cut-up and Deboning of Poultry	ISR/D Q
553 1/2/74	Extension of Time for Cured Meat Product Labeling	PLS/F Q,P,T,U-U-2
563 1/2/74	Labeling Frozen Dinners	PLS/F Q,P,T,U-U-2
586 1/24/74	Certified Pork--Trichinæ Control by Refrigeration	ISR/G Q,P,T,U-U-2
611 2/14/74	Exports of Horsemeat to the United Kingdom	FPS/J P,Q,T,U-U-1
616 2/22/74	MPI Bulletin 367	IC/H Q,P,T,U-U-2
619 2/25/74	MPI Directive 918.1, Poultry Carcass Inspection Program	ISR/C Q
629 3/5/74	Sorbitol in Cooked Sausages	PLS/G Q,P,T,U-U-2
648 3/20/74	Sampling Method for Establishment Not Using the Online Plan for Ready-to-Cook Young Chickens	ISR/C Q,P,T,U-U-2
650 3/19/74	Labeling Meat and Poultry Products with Nonmandatory Features at Locations Other than Official Establishments	PLS/F Q,P,T,U-U-2
670 4/12/74	Operations, Procedures and Equipment	PFE/B Q,P,T,A,I,J, K,L,M,N,O
742 6/21/74	Procedures for Controlling Temperatures of Smoking and/or Drying Rooms in Plants Processing Country Cured Pork Products	ISR/G Q,T,U-U-2

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784 8/5/74	Poultry Carcass Inspection Program--Mature Chickens	ISR/C All MPI Codes
800 9/4/74	Procedures for Controlling Temperatures of Smoking and/or Drying Rooms in Plants Proc- essing Dry-Cured Pork Products	ISR/G Q,P,T,U,U-2
809 9/10/74	Perishable, Heat Processed Canned Meat Products	PLS/G Q,P,S,U-U-2
75-3 1/2/75	Control of Canning Oper- ations Conducted at Official Establishments	ISR/G Q,P,S,T,U-U-2
75-4 1/2/75	Flexible or Semirigid Retortable Packages	ISR/PLS/F P,Q,S,T,U-U-2
75-56 3/21/75	Poultry Carcass Inspection Program--Turkeys	ISR/C A-O P,Q,S,T,U-U-2
75-99 6/26/75	Universal Product Code and Postal Zip Code Added to Labeling	PLS/F A-O, P,Q,S,U
75-105 7/15/75	Asbestos Filters	PFE/B A-O,P,Q,S,U-U-2
76-6 1/7/76	Items Used with Meat or Poultry Products that are Unapproved or Approved but Unacceptable	ISR/A A-O,P,Q,S,U
76-29 2/20/76	Canning Operations and Critical Control Factors	ISR/G A-O,P,Q,S,T,U,U-2

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76-60 4/16/76	Labeling Meat Quality & Yield Grades	PLS/F A-O,P,Q,S,U,U-2
76-123 8/3/76	MPI-APHIS Management and Communication System Coordination	WSDS/A A-O,Q
76-145 9/8/76	Classification of Religious (Buddhist) Requirement	ISR/A A-O,P,Q,S,U,U-2
76-179 11/17/76	Inspection Requirements for Certain Uncured Beef Products	ISR/G A-O,P,Q,S,T,U,U-2
77-18 2/9/77	Labeling Meat Quality & Yield Grades	STS/F A-O,P,Q,S,U,U-2
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77-34 3/16/77	Chemical Disinfection in Lieu of 180° F. Water	SDS/B (Issuances)
77-65 5/13/77	Thirty-Thirty Test for Percent Pump	SDS/G A-O,P,Q,S,U,U-2
77-66 5/17/77	Energy	PFE/A (Issuances)
77-71 5/24/77	Random Sampling Requirements for Residue Monitoring	SS/K A-O,P,Q,S
77-76 6/8/77	Cheesefurter Samples for Added Water Compliance	SS/K A-O,P,Q,S
77-91 6/29/77	Minimum Count	TS/G A-O,P,Q,S,U
77-92 7/6/77	The Implementation of the National Interim Primary Drinking Water Regulations and Their Effect on the Meat and Poultry Inspection Program	PFE/B A-O,P,Q,S,U,U-2

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77-129 11/11/77	Water Conservation and Sanitation	SDS/B (Issuances)
78-16 2/7/78	MPI Directives Checklist	IC/A M90,M07-M12,M50
78-32 3/14/78	Grade Specifications for Product Purchased Under Government Contract	FSR/F M90,M09-M12, M93-M95,M50
78-35 3/16/78	Establishment Numbers	WSDS/A M90,M09,M10
78-40 3/28/78	Disposition of Contaminated Poultry Carcasses	ISR/C M90,M09-M12,M25 M29,M93
78-48 4/19/78	Sequenced Inspection	ISR/C M90,M09-M12,M25,M29
78-62 6/6/78	Bacon Sampling Program	MPI/DA/G M90,M09-M12,M22, M28,M32,M50
78-63 6/6/78	Implementing Bacon Regulations	PLS/G M90,M09-M12,M22,M28 M32,M50
78-72 7/14/78	Label Approval for Product Intended for Export	PLS/F M90,M09-M12,M94
78-74 7/14/78	Implementation of the Bacon Regulations and Sampling Programs	TS/D/G M90,M09-M12,M22,M28, M32,M50
78-84 8/8/78	Alerting Food and Drug Administration of Repeat Violators	SS/K M90,M09-M12,M50

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78-86 8/8/78	Bacon Sampling Requirements-- Retention Phase	MPI/DA/G M90,M09-M12,M22, M28,M32,M50,M04
78-87 8/10/78	Inspection of Contract Specification Program	F0/G M90,M09-M12,M94,M95, M50
78-95 9/7/78	Reporting Swine Sulfonamide Violations	F0/K M90,M09-M10
78-105 10/16/78	Stork Continuous Type Retorts	PFE/B M90,M09-M12,M94,M50
78-107 10/19/78	Labeling Poultry Breasts	F0/F M90,M09-M12,M15,M17
78-110 10/26/78	Labeling of Proprietary Mixtures	PLS/F M90,M09-M12,M27,M28, M50
78-111 10/26/78	Reinspection of Poultry Necks and Giblets	AM&PMI/C M90,M09-M12,M25
78-122 11/22/78	Performance Awards Program for Veterinary Medical Officers and Food Inspectors	MFS/A M90,M09-M12
78-128 11/27/78	Export of Equine Meat	FPS/J M90,M09-M12,M25,M27
78-129 12/1/78	Cooked Beef from Argentina	FPS/J M90,M09-M11,M14,M04
78-133 12/5/78	Conditions of Use of Accepted Equipment	PFE/B M90,M09-M12,M94,M95, M50

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79-31 4/12/79	Post-Mortem Inspection, Young Chickens	TS/C M90,M09-M12
79-33 4/30/79	Boneless Meat Reinspection of Reconditioned Lots	PPIS/G M90,M09-M12,M18,M28, M50
79-40 5/4/79	Modified Traditional Inspection	TS-API/C M90,M09-M12,M92,M94
79-42 5/7/79	Poultry Carcass Inspection Program-Ducks	TS-API/C M90,M09-M12,M50,M94
79-45 5/10/79	Abnormal Cans and Process Deviations	PPIS/K M90,M09-M12,M15,M18, M94
79-51 5/10/79	Dissemination of Laboratory Results	FO/A M90,M92
79-63 6/13/79	FSQS Form 6200-1	SCI/I M90,M09-M12,M04
79-65 6/19/79	Spray-on Polyurethane	PFE/B M90,M09-M12,M94,M95, M50
79-68 6/21/79	Use of Iodine in Processing Water	FESS/B M90,M09-M12,M94,M50
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79-72 7/11/79	Carcass Reinspection--Turkey	SISP-TS/C M90,M09-M12,M25
79-75 7/23/79	Protection of Potable Water Supply on Official Premises	FESS/B M90-M09-M12,M94
79-83 8/3/79	Swab Test on Premises	SCI/K M90,M09-M12,M94,M04

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79-91 8/23/79	Utilization of Energy	FESS/B M90,M09-M12,M94
79-99 9/26/79	Mailing to Residue Samples	DA-MPI/K M90,M09-M12,M25,M26, M04
79-105 10/2/79	Use of Plastic Strip Doors	FESS/B M90,M09-M12,M93-M95, M50
79-111 11/8/79	The Reuse of Brine on Product in Impervious Containers	FESD/G M90,M09-M12,M28
79-113 11/19/79	Export Shipments to Singapore Transiting Hong Kong	FPS/J M90,M09-M12,M94
79-115 11/28/79	Testing of Canadian Pork for Sulfonamide Residues	FPS/J M90 M09-M11, M14,M04
80-1 1/22/80	Correction to MPI Bulletin 77-114	RES/K M90,M09-M12,M50
80-4 1/29/80	Sampling Plan for Turkey Carcasses with Necks	TS/SISP/C M90,M09-M12,M25
80-5 1/29/80	Export of Poultry to U.S. Forces in West Germany	FPS/J M90,M09-M12,M25,M27
80-10 2/25/80	Use of Additional Unidentified Microbial Inhibitors Info. from Laboratories	FO/K M90,M09-M12,M04

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80-18 3/18/80	Treatment of Meat with Chlorinated Water	FESD/B M90,M09-M12,M94,M50
80-20 3/21/80	Export of High-Quality Beef to the European Economic Community (EEC)	FPS/FO/J M90,M09-M12,M26,M28
80-22 3/28/80	Deceptive Labeling Practices	MPI/DA/F M90,M09-M12,M94,M50
80-26 4/29/80	Export of High-Quality Beef to the European Economic Community (EEC)	FPS/FO/J M90,M09-M12,M26,M28
80-27 5/5/80	Diagnostic Pathology Laboratories	SCI/K M90,M09-M12,M04
80-31 6/18/80	Guidelines for the Disposition of Gall-Contaminated Giblets	TS/C M90,M09-M12,M15,M94
80-32 6/18/80	Use of Bovine Tongues to Remove Loose Hair from Carcasses	D M90,M09-M12,M16,M26
80-38 7/15/80	Reduction of Injuries	SCI/K M90,M10-M12,M50
80-40 8/5/80	Clarification of MPI Bulletin 80-1	SCI/K M90,M09-M12,M50
80-46 9/3/80	Preparation of Companion Samples for Chemical Analyses	SCI/K M90,M09-M12,M04

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80-48 9/19/80	Submission of Weekly MP Forms 403 and 404	IEDM/I M90,M09-M12,M16,M18, M20,M22,M28,M31,M32
80-53 10/24/80	Export of Fresh Beef to Australia	FPD/J M90,M09-M12,M26,M28
80-59 11/12/80	STOP Reporting Problems	SCI/K M90,M09-M12,M04
80-67 12/5/80	January 1, 1981, Changeover Date for MPI Form 404 Quarterly Reporting	IEDM/I M90,M09-M12,M28
80-68 12/12/80	Livestock Slaughter Data	FO/I M90,M09-M12,M21,M26
81-1 1/2/81	Import Certification	FPD/J M90,M09-M12,M14
81-6 1/8/81	Handwashing Facilities at Outside Inspection Stations	SISP/TS/C M90,M09-M12,M25,M29
81-9 2/11/81	Humidify STOP Incubators	SCI/K M90,M09-M12
81-12 2/20/81	Export Certificates for DOD Products	ECS/J M90,M09-M12,M26,M28
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81-27 6/22/81	Approval of Partial Plant Quality Control Programs	PPID/G M90 ,M09-M12 ,M94
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81-36 8/11/81	MPI Data Center Mailing Address	IEDM/A M90 ,M09-M12
81-37 8/20/81	Export of Poultry Products to the Netherlands	ECS/J M90 ,M09-M12 ,M25 ,M27
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81-40 8/31/81	Meat Branding Ink	SCI/F M90 ,M09-M12 ,M94
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81-48 10/5/81	Sources of Water for Reuse in Washing and/or Rinsing of Livestock Pens	MPITS/FESD/B M90,M09-M12, M94
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81-50 10/5/81	Delivery/Purchase Order Numbers on Export Certificates for Military	M90,M09-M12,M94
81-51 10/23/81	Export of Partially Defatted Beef Fatty Tissue to Japan	MPIO/ECS/J M90,M09-M12,M94
81-53 11/16/81	Application for Approval of Labeling	MPITS/SLD/F M90,M09-M12,M94
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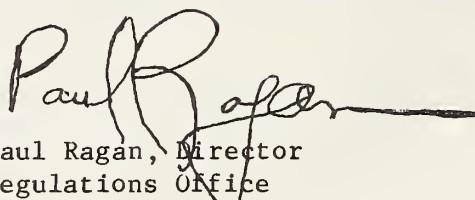
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Paul Ragan, Director  
Regulations Office

UNITED STATES DEPARTMENT OF AGRICULTURE  
Food Safety and Inspection Service  
Meat and Poultry Inspection  
Washington, D.C. 20250

## Meat and Poultry Inspection Manual

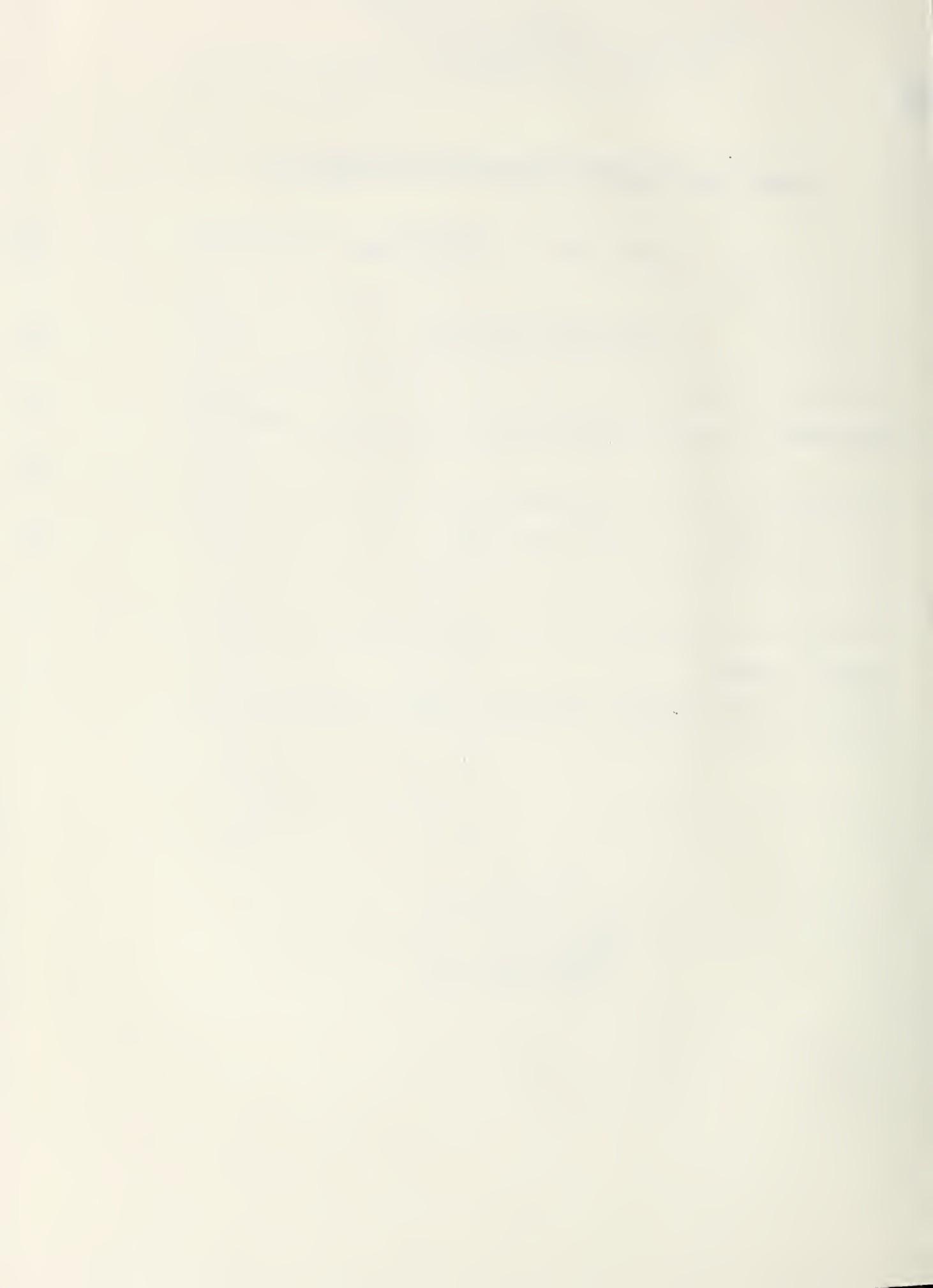
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67 through 70	67 through 70	82-11/12
277 through 294a	277 through 294g	82-11/12

### Pen and Ink Change

Page 259, Section 22.39(1), third line - after the word export, add "further processed products".



3. Observe head's surfaces and eyes.
  4. Incise and observe parotid lymph nodes, lateral and medial masticatory muscles.
- (iii) Tongue out - base down.
1. Incise lymph nodes attached to the tongue--atlantal, mandibular, suprpharyngeal.
  2. Observe and palpate tongue.
  3. Observe head's surfaces and eyes.
  4. Incise and observe parotid lymph nodes, lateral and medial masticatory muscles.

**(2) Viscera inspection.**

1. When evisceration is done into viscera truck(s), follow procedures described under "hind quarter inspection" unless a carcass (rail) inspector is assigned, then observe eviscerated carcass. If evisceration is done onto moving top table, observe eviscerated carcass.
2. Observe mesenteric lymph nodes, and abdominal viscera.
3. Observe and palpate ruminoreticular junction.
4. Observe esophagus and spleen.
5. Incise and observe lungs' lymph nodes--mediastinal (posterior, middle, anterior) and bronchial (right and left).
6. Observe and palpate costal (cured) surfaces of lungs.
7. Incise heart, from base to apex or vice versa, through interventricular septum, and observe cut and inner surfaces.

Alternative. At plant management's request, the heart may also be inspected as follows: After the inspector examines the heart's outer surface, a plant employee must completely evert it, after cutting through the interventricular septum and other tissues. The inspector then examines the inner surfaces and makes not more than four deep, lengthwise incisions into septum and ventricular wall. If cysticercosis is suspected, more incisions shall

be made. Cutting through the heart's walls should be avoided. If necessary, carcasses and hearts shall be identified with consecutively numbered tags.

8. Turn lungs over; observe ventral (flat) surfaces and heart's outer surface.
9. Incise and observe hepatic (portal) lymph nodes.
10. Open bile duct (both directions) and observe its content.
11. Observe and palpate liver's ventral surface.
12. Turn liver over, palpate renal impression, observe and palpate parietal (dorsal) surface.

**(3) Carcass inspection.** It must be done after carcass splitting and before washing. Depending upon facilities available, carcass inspection may be divided into "hindquarter," "forequarter," and "complete" inspection.

**(i) Hindquarter inspection.** Used where viscera and carcass inspections are combined.

1. Observe back of skinned carcass while eviscerated.
2. Palpate superficial inguinal, or supramammary, and internal iliac lymph nodes.
3. Observe body cavities.

**(ii) Forequarter inspection.** It completes carcass inspection started under "hindquarter inspection."

1. Observe cut surfaces of muscles and bones, diaphragm's pillars and peritoneum.
2. Observe and palpate kidneys and diaphragm.
3. Observe pleura, neck, and carcass exterior.

**(iii) Complete inspection.** Used in moving lines with separate carcass inspection stations.

1. Palpate superficial inguinal, or supramammary, and internal iliac lymph nodes.
2. Observe lumbar region.
3. Observe and palpate kidneys.

4. Observe diaphragm's pillars and peritoneum.
5. Observe and palpate diaphragm.
6. Observe pleura, cut surfaces of muscles and bones, neck, and carcass exterior.

**(i) Calves**

- (1) Skinned carcass.
- (i) Head inspection.
  1. Observe head's surfaces.
  2. Incise and observe suprapharyngeal lymph nodes--left and right.

**(ii) Viscera inspection.**

1. Observe and palpate lungs' lymph nodes--bronchial, mediastinal--costal (curved) surfaces of lungs, and heart.
2. Turn lungs over and observe ventral (flat) surfaces.
3. Observe spleen.
4. Observe and palpate dorsal surface of liver.
5. Turn liver over, observe ventral surface and palpate portal lymph nodes.
6. Observe stomach and intestine.

**(iii) Carcass inspection.**

1. Observe outer and cut surfaces.
2. Lift forelegs and observe neck and shoulders.
3. Observe body cavities.
4. Observe and palpate internal iliac lymph nodes and kidneys.

**(2) "Hide-on" carcass.** Inspection procedures of "hide-on" carcasses must include observation of hide for contamination, parasitic conditions and other abnormalities, and palpation of back for grubs.

**(3) Large calves.** Inspection of large calves shall be as described for cattle.

**(j) Sheep and Goats**

- (1) Viscera inspection.
  1. Observe abdominal viscera, esophagus, mesenteric lymph nodes, and omental fat.
  2. Observe bile duct and content, and express gall bladder.

3. Observe and palpate liver (both sides), and costal surfaces of lungs.
4. Palpate bronchial and mediastinal lymph nodes.
5. Observe ventral surfaces of lungs.
6. Observe and palpate the heart. Pancreatic glands. Sheep pancreatic glands, saved for edible purpose, shall be examined for wholesomeness. Tapeworms in bile duct indicate possible infested glands.

**(2) Carcass-head inspection.**

1. Observe outer surfaces of carcass, body cavities--pelvic, abdominal, thoracic--and spleen.
2. Observe and palpate kidneys.
3. Palpate prefemoral, superficial inguinal, or supramammary, and popliteal lymph nodes.
4. Palpate back and sides of carcass.
5. Palpate prescapular lymph nodes and shoulders, and lift forelegs.
6. Observe neck, shoulders, and head.

**(3) Lymph node incision.** Inspectors shall incise body lymph nodes when palpation is inadequate to determine absence of caseous lymphadenitis. Incised nodes should remain attached to the carcass for final inspection.

**(k) Swine**

Inspectors must examine carcasses, organs, and parts for diseases, abnormalities, cleanliness.

**(1) Head inspection.**

1. Observe head and cut surfaces.
2. Incise and observe mandibular lymph nodes.
3. Observe/retain carcass when required.

**(2) Viscera inspection.**

1. Observe eviscerated carcass, viscera, and parietal (top) surface of spleen.

- \* 2. Observe and palpate mesenteric lymph nodes.
- \* 3. Palpate portal lymph nodes.
- \* 4. Observe dorsal surfaces of lungs.
- \* 5. Palpate bronchial lymph nodes.
- \* 6. Observe mediastinal lymph nodes.
- \* 7. Turn lungs over and observe ventral surfaces.
- \* 8. Observe heart.
- \* 9. Observe dorsal surface of liver.
- \* 10. Turn liver over and observe ventral surface.
- \* 11. Condemn viscera or parts when required.
- \* 12. Retain carcass, viscera, and parts when required.

**(3) Carcass inspection.**

- \* 1. Look in mirror and observe back of carcass. NOTE: Where mirror is not required, turn and observe back of carcass.
- \* 2. Observe front parts and inside of carcass.
- \* 3. Grasp, turn, and observe kidneys (both sides).
- \* 4. Direct trim, remove retain tags, or retain carcass when required.

**(4) Responsibility.** Plant management should assure that all heads, viscera and carcasses are prepared and presented for inspection adequately so the inspector needs not perform additional steps to examine them.

When, in the inspector's in charge judgment, any of the above steps cannot be performed at the current slaughter line speeds because of preparation or presentation deficiencies, or because of disease incidence, the inspector in charge will require the establishment to reduce the line speed until all conditions are favorable.

**(I) Horses and Other Equines**

**(I) Head inspection.**

1. Observe head's surfaces.
2. Observe and palpate (incise when necessary) mandibular, pharyngeal

and parotid lymph nodes, guttural pouch, and tongue.

**(2) Viscera inspection.**

1. Observe and palpate lungs, bronchial and mediastinal lymph nodes (incise when abnormal).
2. Incise and observe heart as for cattle.
3. Observe and palpate spleen, liver (both surfaces), and portal lymph nodes.
4. Open hepatic (bile) duct as for cattle.
5. Observe rest of viscera and body cavities.

**(3) Carcass inspection.** Inspect as for cattle (11.1(h)(3)). In addition, observe (and incise when necessary):

1. Inner abdominal walls for encysted parasites.
2. Spinous processes of thoracic vertebrae, supraspinous bursa, and first two cervical vertebrae for fistulous conditions.
3. Axillary and subscapular spaces of white and gray horses for melanosis.

**(m) Kidney Inspection**

Before viscera or carcass inspection, plant employees shall adequately expose all kidneys of livestock carcasses from fat covering and capsule. The inspector shall then examine them during viscera or carcass inspection. When examined with the viscera, kidneys must be removed from the carcass and presented for inspection with other organs.

**(n) Poultry**

Inspector in charge is responsible for frequently assuring that poultry is properly defeathered and adequately presented for inspection.

Product must meet ready-to-cook requirements before chilling.

**(I) Carcass-viscera inspection.**

1. Observe and palpate tibia (drumstick).
2. Observe hock joints.
3. Open body cavity and observe inner surfaces and organs.

4. Observe and palpate liver, heart, and spleen. Crush spleen of mature poultry.

5. Observe other viscera and carcass exterior.

6. Instruct trimmer on disposition of abnormal or diseased carcasses (hang back, trim, remove viscera, condemn, etc.).

**(2) Inspection rates; line speeds.**

**(i) Inspector's responsibility.**

Since under all conditions it is impractical to establish inspection rates and eviscerating line speeds in all plants, the inspector in charge is responsible for determining line speeds resulting in adequate inspection.

The highest speed may vary depending upon various factors--poultry class and presentation, disease incidence, plant personnel ability to sanitarily accomplish eviscerating procedures, etc.

The inspector in charge shall reduce line speeds when necessary, and shall increase them back to normal when all conditions are favorable.

**(ii) Facilities and procedures.** The following facilities and procedures are required:

1. Lighting--of enough intensity, uniform, and properly directed at work levels.

2. Hand-washing facilities--adequate and properly located.

3. Lines with two or more inspection stations--with dividers or marked shackles to prevent inspectors' confusion.

4. Shackle suspensions--suitable for poultry carcass.

5. Conveyor belts or pans (when used)--synchronized with overhead conveyors and sanitized when saving viscera for edible purpose.

6. Line start and stop control--within inspector's reach.

7. Inspector's worksheet holder--conveniently located for inspector and helper.

8. Trained inspector's helper.

9. Carcass and viscera--adequately presented for inspection to allow prompt examination of entire carcass (inner and outer surfaces), and all organs. Visceral organs--heart, liver, gizzard, etc.--must be presented close to the carcass, (not farther than 6 inches and preferably suspended by natural attachments below the carcass opening).

10. Foreman's cooperation. Close cooperation between foreman and inspector is always necessary.

**(iii) Inspection rates; studies.**

Studies show that as disease incidence increases inspector's errors increase unless line speeds are reduced. Thus, lines should be operated at rates that result in product showing no evidence of inspection errors.

Table 11.1 shows study results on highest inspection rates obtained in some poultry plants without errors. For the various factors involved, such rates may be used as a guide and not be considered standards.

**(iv) Product flow.** To prevent contamination and bacterial buildup and to comply with chilling requirements, line speeds must result in smooth product flow (no pileup). Giblets shall be processed to ready-to-cook stage at carcass speed rate.

## II.2 DELAYED INSPECTION (LIVESTOCK)

Low volume plants are eligible for delayed post-mortem inspection, provided:

1. Carcasses and organs are inspected on slaughter day, unless otherwise approved by RD.

2. Sanitation inspection of facilities, equipment, and plant employees' clothing is done during post-mortem inspection.

3. Ears with identification tags and tattoos (swine) are left attached to carcasses until inspected.

### 26.3 FOOD INSPECTION SERVICE

This service provides for supervision of the preparation of certain food items containing meat, meat byproducts, or meat food products as ingredients which are not subject to FMIA. Application for this service should be accompanied by a brief description of proposed food article to be prepared and a complete description of the preparation method with the formula and ingredients listed by percentage.

Regular export stamps and certificates may be issued at applicant's request.

#### (a) Facilities

A facility review will be made by circuit supervisor who will apply the Federal facility requirements. Blueprints are not required.

#### (b) Labels

Label requirements are as those for Identification Service.

#### (c) Ingredients

Only federally inspected meat, meat byproducts, and meat food products will be used as ingredients of food article. Other ingredients must meet the same standards of wholesomeness as those used in federally inspected plants.

Necessary sampling and laboratory time are reimbursable and must be shown on MP Form 11.

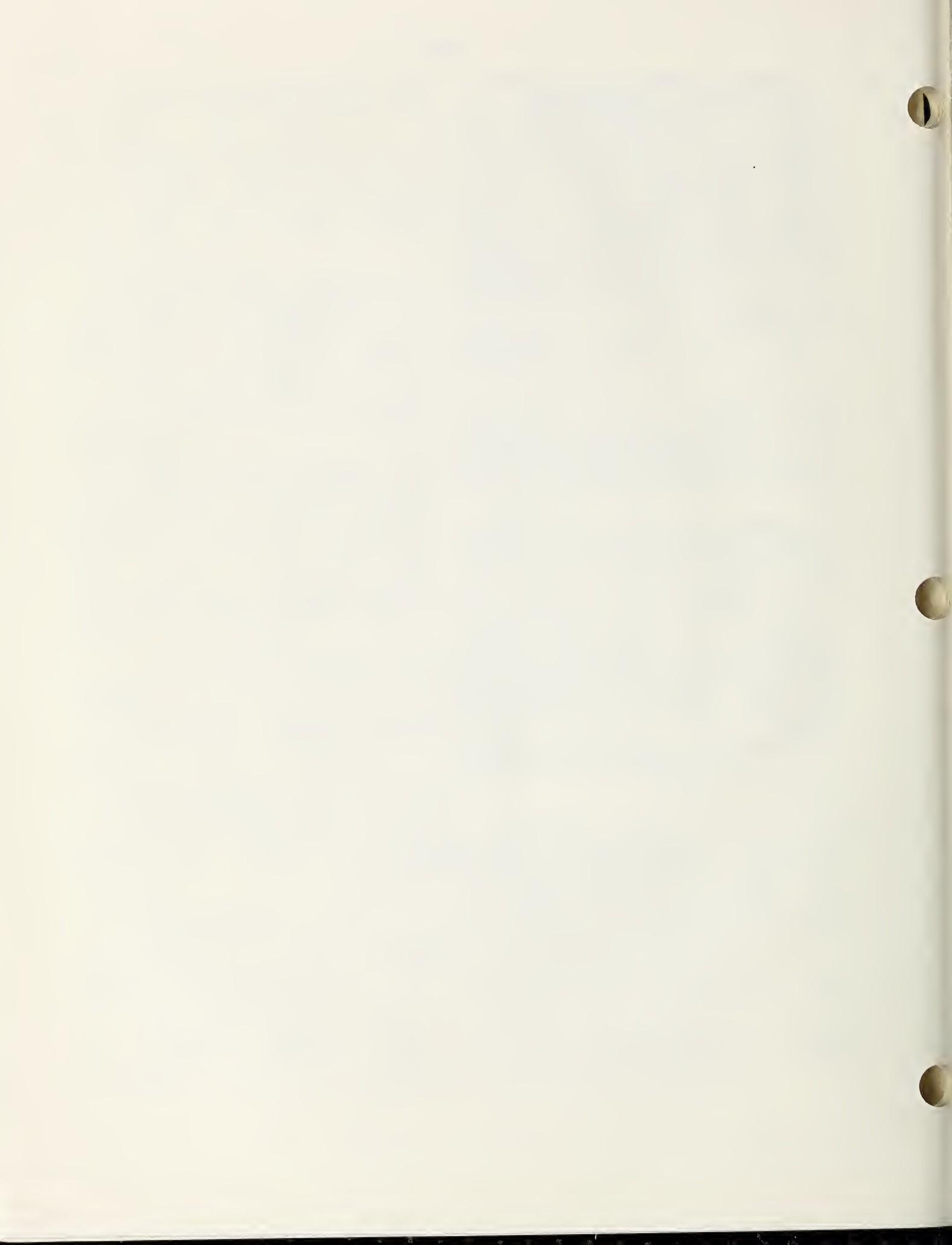
### 26.4 INEDIBLE CERTIFICATE FOR EXPORT

MPI may certify inedible materials for export at VS request. MP Form 11 must be completed to bill the plant for VS.

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## IMPORTS

## SPECIAL REQUIREMENTS

## Subpart 27-A

\* (Regs:M-301, 316, 327; P-Subpart A, T)

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**\* 27.1 DEFINITIONS**

\* For purposes of this Part, the  
\* following definitions will apply.

\* (a) General

\* (1) Automated Import Information

\* System (AIIS). A centralized, computer  
\* based, data processing system which  
\* maintains all available information  
\* relating to imported product and  
\* assigns inspection levels and  
\* procedures based upon established  
\* sampling rules and compliance history.

\* (2) Inspection Assignment. Instructions generated by the AIIS detailing  
\* the type(s) of inspection to be  
\* performed (TOI), sampling status of the  
\* product lot(s) (objective or selective)  
\* and, where applicable, random sampling  
\* data.

\* (3) Laboratory Sample. A product sample (for other than residue analysis) submitted for one or more of the following reasons:

- \* a. Previous non-compliance
- \* b. Lack of product history
- \* c. To confirm inspector's suspicions
- \* d. Specific Program needs
- \* e. Maintain product compliance history. Samples collected in categories a through d above may require that the lot be placed on "sample and hold"

(4) Sample and hold. Retention of \*  
product lots pending receipt of certain \*  
"laboratory sample" analytical results. \*

(5) Type of Inspection (TOI). A \*  
series of code letters appearing on \*  
the Inspection Assignment directing \*  
import inspection personnel to perform \*  
specific types of inspection and/or \*  
sampling, based upon type of product \*  
and compliance history.

(6) Code Marks. Markings which \*  
identify a lot or a distinct portion of \*  
a lot either by type of meat (hinds, \*  
fores, shanks, etc.) or a production \*  
run (day or period of day).

(7) Consignee. The person or party \*  
to whom the imported product is \*  
destined.

(8) Consignor. The person or party \*  
who sold the imported product to the \*  
consignee.

(9) Sampling Inspection. That type \*  
of inspection in which samples \*  
consisting of one or more units of \*  
production are selected at random from \*  
the completed lot and examined for one \*  
or more quality characteristics. \*  
Based upon this examination certain \*  
assumptions are made concerning the \*  
overall compliance of the lot.

(10) Sample. That portion of an \*  
imported lot used to estimate whether \*  
or not the lot is acceptable. Samples \*  
may at times be further sub-divided \*  
into sample units.

(11) Sample Units. A group of units \*  
forming a sample which are individually \*  
selected, identified and evaluated. A \*  
boneless meat reinspection, for \*  
example, may require a 72 pound sample \*  
consisting of six 12-pound sample \*  
units.

\* (12) Random Sample. A sample drawn in such a manner that every unit within the lot has an equal chance of being selected.

\* (13) Proportionate Sample. A random selection method which assures that individually coded portions of a lot are adequately represented in the total sample. (Can only be used when differently coded portions of a lot are separated for sampling.)

\* (14) Lot. A group of similarly processed/packaged product from one country, one establishment, and consisting entirely of one product code.

\* (15) Official Control. Inspectional restraint or direction without official security.

\* (16) Official Security. Inspectional restraint by use of an official device. (Seal, lock, crosstaped and stamped, etc.)

\* (17) Solid Mixed Product. Includes canned hams and picnics, slab bacon, or other solid single unit type products.

\* (18) Tempering. Removal of frost or ice glaze from surfaces of frozen meat cuts to facilitate product examination.

#### \* (b) Canning Definitions

\* (1) Buckle. A permanent distortion of the container end due to excessive internal pressures developing during heat processing.

\* (2) Cable cut. An abrasion of the top of the container double seam caused by the action of moving cable conveyors on stationary cans.

\* (3) Delamination. Separation of layers of packaging material that results in the questionable integrity and safety of the product.

\* (4) Flexible container. The shape or contour of the filled, sealed

container generally takes the shape of \* the enclosed product. The retort \* pouch is a common example. \*

(5) Flipper. A rigid metal container which normally appears flat, \* but when brought down sharply on the end on a flat surface, one end will flip out. When pressure is applied to this end, it will flip in again and the can will again appear flat (normal). \*

(6) Improper closure seal. Defects (e.g., entrapped food, grease, moisture, voids, fold-over wrinkles) in that area of the closure seal which extends 1/8 inch vertically from the edge of the seal on the food product side and along the full length of the seal. \*

(7) Improper tear notch. Less than 3/16 inch of defect-free seal from the end of the tear notch to the inner edge of the seal. \*

(8) Loose tin. End or ends of a rigid or semi-rigid container that do not show evidence of full vacuum, thus allowing movement. \*

(9) Overfill. Excess product in a container causing can ends to bulge. Usually identified by determining product net weight. \*

(10) Semi-rigid container. The shape or contour of the filled, sealed container is not affected by the enclosed product under normal atmospheric temperature and pressure, but can be deformed by normal firm finger pressure. \*

(11) Springer. A container (rigid or semi-rigid) with one end permanently bulged. When sufficient pressure is applied to this end, it will flip in, but the other end will flip out. \*

(12) Swell. A container which is bulged by excess internal pressure. \*

**\* 27.2 ELIGIBILITY****\* (a) Countries**

\* To enter the United States, products  
 \* must originate from approved countries  
 \* (see Table 27.1), or be determined by  
 \* the Administrator to be exempt from  
 \* regulations.

**\* Table 27.1 - Country Codes**

* Argentina	150
* Australia	160
* Austria	165
* Belgium	190
* Brazil	220
* Belize	230
* Bulgaria	245
* Canada	260
* Rep. of China	281
* Colombia	285
* Costa Rica	295
* Czechoslovakia	310
* Denmark	315
* Dominican Rep.	320
* El Salvador	330
* France	350
* Germany	390
* Guatemala	415
* Haiti	420
* Honduras	430
* Hong Kong	435
* Hungary	445
* Iceland	450
* Ireland	470
* Israel	475
* Italy	480
* Japan	490
* Mexico	595
* Netherlands	630
* New Zealand	660
* Nicaragua	665
* Norway	685
* Panama	710
* Paraguay	715
* Poland	730
* Romania	755
* Spain	830
* Sweden	850
* Switzerland	855
* Taiwan	860
* United Kingdom	925
* England-Wales	925E

**N. Ireland****Scotland****Uruguay****Yugoslavia****925I****925S****930****970**

\*

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\*

\*

**(b) Plants**

Only products from foreign plants  
 approved (listed) by the meat and  
 poultry inspection program are  
 acceptable.

Product from foreign plants received  
 after eligibility withdrawal (delist-  
 ment) must be certified that it was  
 produced before delisting date, or  
 production dates listed on the  
 certificate (see section 27.3(a)) must  
 show the product was produced during a  
 time of eligibility to export to the  
 United States.

**(c) PPQ Restrictions**

(1) Inspector's responsibility. PPQ  
 has certain restrictions on importation  
 of products from specified countries.  
 These restrictions have been entered  
 into the AIIS for proper control.  
 However, inspectors must be aware of  
 such restrictions (see 9 CFR Part 94,  
 VS Memos 593.6, 593.7, 593.9, 593.15,  
 etc.) and must not perform import  
 inspection on any shipment unless all  
 PPQ requirements are met. For  
 questionable shipments contact the  
 computer terminal operator for  
 clarification.

(2) Poultry from France. The only  
 poultry products which may be imported  
 from France are those manufactured from  
 ducks or geese. Such products may be  
 received in combination with red meat  
 or red meat byproducts.

(3) Certification. Ruminant and  
 swine products from foot and mouth  
 disease, hog cholera, African swine  
 fever, and swine vesicular disease  
 designated countries must be accompa-  
 nied by required certification.  
 Poultry and poultry products from  
 viscerotropic v<sup>e</sup>logenic Newcastle  
 disease designated countries must  
 also be accompanied by required  
 certification.

\* (4) Cooked Beef from South America.  
 \* Individual tubes of cooked boneless  
 \* beef may contain pieces as small as  
 \* 3/8 inch square provided the identity  
 \* of the tissue is retained. No ground  
 \* meat is permitted to be included in the  
 \* tube. Each tube of cooked beef must  
 \* have, in the approximate center of the  
 \* tube (the area farthest from all  
 \* surfaces of the tube), at least one  
 \* solid piece of meat at least 1½ inches  
 \* cube in size. During import inspection  
 \* this piece will be removed from the  
 \* tube, cut in half, and compressed to  
 \* observe for the presence of pink  
 \* juices. If pink juices are detected,  
 \* the entire lot is to be retained and  
 \* PPQ notified through channels.

\* (d) Other agencies

\* MPI will not consider any shipment for  
 \* import inspection until it has been  
 \* cleared by PPQ, and U.S. Customs has  
 \* officially assigned an entry identifi-  
 \* cation number. Shipments identified  
 \* with U.S. Customs "Warehouse Entry"  
 \* numbers will not be given import  
 \* inspection while in this category and  
 \* the importer shall submit, without  
 \* delay, a copy of the Customs warehouse  
 \* entry form to MPI. MPI shall monitor  
 \* all such warehouse entries.

**\* 27.3 CERTIFICATION**

\* (a) Regular Certificate

\* To identify any product or shipment as  
 \* having been certified by foreign  
 \* officials before export to the United  
 \* States, an official foreign meat  
 \* inspection certificate from the country  
 \* of origin must be presented with the  
 \* request for inspection of all products  
 \* other than those exempted by the  
 \* Administrator. Such certificates shall  
 \* be: (1) As required by regulations  
 \* (M-327; P-Subpart T), (2) identified as  
 \* the original and, (3) signed by an  
 \* authorized official of the exporting  
 \* country.

\* (b) Erasures, Alterations

\* A foreign meat inspection certificate  
 \* is an official document of a foreign

government eligible to export to the\*  
 United States. For continued U.S.\*  
 acceptance of these certificates, and\*  
 to maintain their integrity, foreign\*  
 officials must exercise extreme care in\*  
 their completion. The United States\*  
 will not accept erasures or alterations\*  
 on any certificate. \*

**(c) Unacceptable Certificates**

When certificates are incorrect or\*  
 otherwise unacceptable, corrected\*  
 certificates may be requested from the\*  
 originating country's embassy by the\*  
 importer. Inspection shall be withheld\*  
 until a new certificate is received or\*  
 the originating country embassy\*  
 provides the regional office with a\*  
 guarantee of certificate replacement. \*

The embassy shall call the regional\*  
 office through which the product is\*  
 offered for import. Regional offices\*  
 shall establish written procedures for\*  
 maintaining records of all such\*  
 transactions. The unacceptable\*  
 certificate, together with the\*  
 corrected certificate when received\*  
 shall be maintained in the inspector's\*  
 files along with all other documents\*  
 and forms pertaining to the shipment. \*

**(d) Additional Certification; Examples**

Depending upon country of origin, type\*  
 of product, method of preparation, or\*  
 other special circumstances, certain\*  
 shipments may require additional\*  
 certification. Such certifications\*  
 should appear on the regular\*  
 certificate (original). \*

(1) Pork. Product prepared to be\*  
 eaten without cooking and containing\*  
 pork muscle tissue must have trichinae\*  
 certification as required by regula-  
 tions (327.4(b)). Such certification\*  
 is not required for canned product\*  
 since it is heated to a temperature\*  
 that destroys trichinae. \*

(2) Spring lamb. A statement is\*  
 required for "New Zealand genuine\*  
 spring lamb" carcasses and/or product\*  
 indicating that they are from new crop\*

\* lambs slaughtered in New Zealand from  
 \* October 23 through the following  
 \* May 31.

\* **(3) Shankless lambs.** Lambs without  
 \* attached foreshanks require a state-  
 \* ment indicating the product is from  
 \* ovine animals less than 1 year old,  
 \* and foreshanks are broken at the  
 \* distal epiphyseal cartilage of  
 \* metacarpal bone.

**(e) Lot Division; Certificate**

**Photostats**

\* Occasionally, product covered by one  
 \* certificate may be divided into several  
 \* lots, and scheduled to be unloaded at  
 \* various ports or shipped to different  
 \* destinations for inspection. In such  
 \* cases, import inspection supervisor  
 \* receiving the original certificate will  
 \* (1) require the importer or his  
 \* representative to furnish enough  
 \* photostats to cover each portion  
 \* shipped to different locations; and  
 \* (2) authenticate each copy by dating,  
 \* signing, including individual  
 \* destination circuit, and indicating  
 \* amount of product being shipped.

\* When a certified lot or shipment  
 \* contains more or less than the amount  
 \* noted on the certificate, the inspec-  
 \* tor will refer to Table 27.2. If the  
 \* variation does not exceed the allowance,  
 \* it may remain in the lot. If it  
 \* exceeds the allowance, the entire lot  
 \* shall be ineligible for import inspec-  
 \* tion until proper foreign certification  
 \* is produced as outlined in Part 27.3(c).

**Table 27.2 - Allowed Variation**

Amount (Units)	
Certified	Allowed
	±
50 - under	0
51 - 100	1
101 - 200	2
201 - 400	4
401 - 600	5
601 - 1,200	6
1,201 - 2,000	7
2,001 - 5,000	8
5,001 - 10,000	10
10,001 - over	15

If the foreign embassy will not \*  
 guarantee and provide a new certificate \*  
 for the entire lot, the entire lot shall \*  
 be refused entry. In any of these above \*  
 instances, the inspector will note the \*  
 variation on all copies of the MP 410 \*  
 before returning the third copy to U.S. \*  
 Customs. If the product is refused \*  
 entry, follow refused entry procedures. \*

**27.4 APPLICATION: MP 410**

**(a) Port of Entry (POE)**

Importers shall prepare MP Form 410 \*  
 and present it to MPI personnel at \*  
 POE.

**(b) Destination inspection**

Whenever products arrive at a U.S. \*  
 port or point of entry where MPI per- \*  
 sonnel are not assigned, importers may \*  
 submit the MP Form 410 to U.S. Customs \*  
 officials who will institute procedures \*  
 for shipping product to destination \*  
 locations where inspection facilities \*  
 and personnel are available. Shipment \*  
 to any destination shall not be made \*  
 without prior assurance that inspection \*  
 facilities and personnel are adequate \*  
 for inspection. Regional offices will \*  
 inform local Customs officials of the \*  
 location of approved facilities and \*  
 type of inspection, i.e., canned \*  
 products, boneless meat, etc., for \*  
 which the facility is approved.

**(c) Consignee**

For importation of meat from horses, \*  
 mules, or other equines, the name and \*  
 address of the ultimate consignee must \*  
 appear on the MP Form 410. Brokers, \*  
 intermediate agents, warehouses, etc., \*  
 are not usually considered ultimate \*  
 consignees.

**(d) Accurate Information**

The inspector and/or computer ter- \*  
 minal operator shall review the MP \*  
 Form 410 for accuracy and return to \*  
 the applicant any application con- \*  
 taining incorrect or unsatisfactory \*  
 information. If a corrected MP 410 \*  
 is required, it shall be conspicuously \*  
 marked "Corrected Copy, Replaces \*  
 MP Form number \_\_\_\_\_" (enter serial \*

\* number of original MP 410) across the  
\* top. The original MP Form 410 shall be  
\* returned with the corrected copy.

**(e) Inspection Location**

\* If import inspection cannot be done  
\* within a circuit for lack of facilities  
\* or inspection personnel, applicants  
\* will be advised where product may be  
\* presented for most expeditious  
\* inspection. Inspection will not be  
\* performed on any lot not accompanied by  
\* MP Form 410. Once an Inspection  
\* Assignment has been issued, there will  
\* be no changes in the inspection  
\* location without authorization from  
\* the Director of the region in which  
\* the Inspection Assignment was first  
\* issued. Regional offices will  
\* immediately notify Foreign Programs  
\* Division of any authorized changes in  
\* inspection location.

**27.5 FACILITIES, EQUIPMENT**

**(a) Approval**

\* The necessary drawings with required  
\* specifications shall be approved by the  
\* Administrator and the facility shall be  
\* constructed in accordance with the blue  
\* print. The applicant agrees to conform  
\* strictly to applicable Federal laws and  
\* regulations pertaining to import  
\* inspection and is responsible to ensure  
\* compliance. The facility must be in  
\* good repair, safe, efficient for proper  
\* inspection and capable of being  
\* maintained in a sanitary manner. If it  
\* becomes necessary to program a  
\* deficiency for correction, it may be  
\* recorded on the regional plant  
\* maintenance form.

**(b) Equipment**

\* Owners or operators of establishments  
\* at which import inspection is conducted  
\* shall furnish adequate equipment for  
\* product examination. This will include  
\* items such as band saws, inedible  
\* containers, scales, knives, ink pads,  
\* tape, weights of known accuracy to  
\* check scales, pans, thermometers,  
\* strainers, grinders, can openers and  
\* similar equipment. Management shall  
\* ensure all equipment such as

thermometers and scales are functional \*  
and accurate. \*

All equipment other than that \*  
identified as exempt in the MPI-2 \*  
"Accepted Meat and Poultry Equipment" \*  
booklet shall be approved by the \*  
Equipment Group prior to use at the \*  
facility. Tables, benches and other \*  
equipment on which inspection is to be \*  
performed shall be of such design, \*  
material and construction as to enable \*  
Program employees to conduct their \*  
inspection in an efficient and sani- \*  
tary manner. \*

**(c) Security**

Security boxes, cages, rooms and \*  
incubation facilities shall be designed \*  
and constructed to provide necessary \*  
security by means of official locks or \*  
seals. Inspectors will check to assure \*  
that security has not been breached. \*

Supervisors will conduct unannounced \*  
reviews of sample security and facility \*  
activity and arrange approved sample \*  
inventory procedures where applicable. \*

**(d) Lighting**

A minimum of 50 foot candles of \*  
shadow-free lighting shall be provided \*  
at all inspection locations. Adequate \*  
lighting in other areas as approved by \*  
the circuit supervisor. \*

**(e) Denaturing Procedures**

An approved denaturant will be supp- \*  
lied by the applicant and be available \*  
at the facility during operations. \*  
Articles in pieces more than 4 inches \*  
in diameter shall be freely slashed or \*  
sectioned before the denaturant is \*  
applied. Articles in cans, jars, or \*  
otherwise packaged shall be removed \*  
from the packaging material prior to \*  
denaturing. Inspection personnel shall \*  
be assured the products are stored in \*  
properly marked containers and \*  
effectively denatured before leaving \*  
the inspection facility. Effective \*  
control procedures shall be implemented \*  
and approved by the circuit supervisor. \*

**(f) Packaging Material**

Poly bags, plastic bags, and similar \*  
packaging material used to enclose \*

\* product for water defrost shall be of  
 \* sufficient strength to prevent leakage  
 \* and/or breakage. A letter shall be  
 \* provided by the supplier indicating  
 \* material acceptance for edible product  
 \* contact. A copy of the acceptance  
 \* letters shall be on file in the  
 \* government office.

**(g) Storage and Staging Areas**

\* These areas shall be maintained in  
 \* a sanitary and safe condition.  
 \* Improperly maintained equipment, such  
 \* as fork lifts leaking operational  
 \* fluids which may contaminate product or  
 \* containers, shall not be used in  
 \* handling meat and poultry products.

**(h) Incubation - Shelf Stable Heat**

**Processed Products**

\* Follow procedures outlined in section  
 \* 27.15(c). The heat sensing element for  
 \* the temperature recording chart shall  
 \* be lower than the lowest shelf storing  
 \* product for incubation. A means of air  
 \* circulation should be provided to  
 \* assure uniform temperature distribu-  
 \* tion.

**(i) References**

\* There are many applicable require-  
 \* ments relative to imports recorded in  
 \* various sections of the Manual. The  
 \* following requirements are not all  
 \* inclusive but are referenced to assist  
 \* inspectors in assuring compliance with  
 \* applicable provisions:

- \* 1. Water Supply - Subpart 8-D
- \* 2. General Sanitation - Subpart 8-B
- \* 3. Personal Hygiene - Subpart 8-C
- \* 4. Sanitation of Facilities and  
     Equipment - Subpart 8-E
- \* 5. Chemical Compounds - Subpart 8-F
- \* 6. Insect and Rodent Control -  
     Subpart 8-G
- \* 7. Special Sanitation Require-  
     ments - Subpart 8-H

**27.6 MARKING, LABELING**

**(a) Approval**

\* Shipping container marks, including  
 \* those for bulk-packed, boneless meat  
 \* shall be approved by the inspector at

each location where the products are \*  
 presented. \*

Labels for immediate containers \*  
 including artificial casings, bags, or \*  
 printed wrappers, must be approved by \*  
 the Meat and Poultry Standards and \*  
 Labeling Division. The foreign \*  
 establishment (or importing) firm shall \*  
 submit the following:

1. A completed copy of FSIS \*  
     Form 8822-1.
2. Copies of the label. The number \*  
     of copies submitted must equal the \*  
     number of ports of entry where the \*  
     product will be entered.
3. Send to Meat and Poultry Stand- \*  
     ards and Labeling Division, MPI \*  
     Technical Service, FSIS, 12th and \*  
     C Street, SW., Agriculture Annex \*  
     Building, Washington, DC 20250. \*

**(b) Product Designation**

Designations such as "bull beef," \*  
 "cow beef," forequarter beef," "hind- \*  
 quarter beef," etc., are not permitted \*  
 as markings. Proper designation is \*  
 "boneless beef" followed by foreign \*  
 country's name.

EXCEPTION! Cheek meat shall follow \*  
 the proper designation such as \*  
 "boneless beef-cheek meat" since it is \*  
 a restricted material in certain prod- \*

ucts.

Individual cuts may be identified on \*  
 cartons by specific accepted names, \*  
 such as "inside rounds," "outside \*  
 rounds," "knuckles," "shoulder clods," \*  
 etc., in conjunction with the "boneless \*  
 beef" designation.

**(c) Industry Marks**

Industry marks on product containers \*  
 for distinguishing various trade \*  
 categories of meat and poultry products \*  
 are permissible but shall not have \*  
 labeling connotations.

**(d) Wholesale Cuts; Byproducts**

Individually wrapped or separate \*  
 wholesale cuts must each bear the \*  
 official origin country's mark of \*  
 inspection and the statement "product \*  
 of (name of country)." Such statement \*  
 is not necessary if the country's name \*

\* appears within the official mark. The requirement also applies to livers, tongues, and separate cuts capable of carrying such markings. Bulk packed boneless meat in cartons need not be individually marked.

**(e) Carcasses (Meat)**

\* When imported carcasses are separated into various cuts normally having an inspection legend, the cuts shall be legibly marked to show the country of origin adjacent to such legend.

**(f) Repackaged Product**

\* When authorized by MPI, imported product may be repackaged under Identification Service. The origin country's name must be marked on each new package.

\* Imported product that is further processed by cooking, grinding, or slicing may be packaged under approved (domestic) label without reference to country of origin. However, if product is identified as "imported," the label must also bear a statement such as "sliced and packed in U.S.A."

**(g) Horsemeat**

\* Horsemeat is required to be marked "horsemeat" with green ink on larger pieces within every carton. At least one such mark is required on each 10 pounds of bulk packed boneless meat.

\* Horsemeat markings or labels must be printed, embossed, or lithographed directly on containers. Attached paper labels are not satisfactory.

**(h) Grade Marks**

\* Imported products bearing grade marks similar to those used by Meat Grading Branch, Livestock Division, AMS, shall not be accepted until such marks are checked and the quality of the product is verified by a Meat Grading Branch representative.

**(i) Label File**

\* All label approvals must be on file at the inspector's office for all products offered for inspection.

**(j) Metric Weight**

See section 17.10(g)

**27.7 MPI COOPERATION**

Inspectors shall fully cooperate with U.S. Customs and other governmental agencies in handling imported products.

**INSPECTION PROCEDURES**

**Subpart 27-B**

(Regs: M-316, 317, 327 P Subpart N, T)

Import inspections are required to determine whether imported product, certified by officials of approved countries, continues to be wholesome and meets U.S. requirements when offered for inspection. Importers shall provide competent personnel necessary for the efficient and effective application of required examinations.

**27.10 LOT PRESENTATION; CONDITION AND ACCURACY**

Inspectors will initially check all lots in their entirety for general condition, proper labeling, and accuracy of count as specified on the MP Form 410 and health certificate. Lots, or portions of lots, demonstrating unacceptable conditions at this point shall be refused entry.

Damaged containers sorted out of a lot shall be examined by the inspector to determine cause and rejected and identified as such on the MP Form 410.

When the sorted product consists of abnormal (i.e., swells, flippers, springers) hermetically sealed containers and the abnormalities are not the direct result of shipping

\* damage, they shall be handled as  
\* outlined in section 27.15(b). The lot  
\* from which they were sorted shall be  
\* placed on "sample and hold."

\* Inspectors shall notify U.S. Customs  
\* of the sorted product and inform the  
\* field compliance office of its  
\* location.

#### \* 27.11 LOTTING; LOT SIZE

\* Importers will designate on the  
\* MP Form 410 how they will present  
\* products (lot size) for inspection.

\* The weight and/or number of  
\* containers of similar product from one  
\* establishment is the "lot size" which  
\* is entered into the computer system to  
\* request an Inspection Assignment.

\* Importers should be encouraged to  
\* present the largest possible lots for  
\* inspection.

\* Non-separately identifiable lots  
\* presented for inspection shall be  
\* combined into a single lot by the  
\* inspector.

#### \* 27.12 SAMPLING; PLANS; SELECTION

\* Inspections are performed using a  
\* variety of statistically sound sampling  
\* plans assigned by the Automated Import  
\* Information System (AIIS) according to  
\* type of product, type of inspection,  
\* and lot size.

\* Sample sizes determined by the  
\* computer system are further identified  
\* as randomly selected sample container  
\* numbers on the Inspection Assignment.

\* When the Inspection Assignment  
\* requires a two-step sampling plan as in  
\* boneless meat reinspection first step  
\* samples will be stamped once with the  
\* "USDA Official Sample" stamp, and  
\* second step samples will be identified  
\* by stamping twice with this stamp.  
\* Both first and second step samples will  
\* be removed from lots, kept separate,  
\* and be available for inspection as  
\* needed.

Wherever the Inspection Assignment \*  
sample container numbers cannot be \*  
used, or are not available, the \*  
inspector shall select random numbers \*  
from other acceptable sources. The \*  
selected numbers, reason for use, and \*  
their source shall be identified on the \*  
"Inspection Worksheet," MP Form 68. \*

When necessary, inspectors may \*  
override the Inspection Assignment \*  
sample container numbers to assure \*  
reasonable sampling representation of \*  
all differently coded containers within \*  
a lot.

Prior to sampling, the inspector \*  
shall determine that the lot is \*  
presented in a manner to provide for a \*  
meaningful count that will assure \*  
accuracy in selection of sample \*  
cartons.

During selection of sample \*  
containers, obviously defective, \*  
damaged, or otherwise suspicious \*  
containers shall not be excluded from \*  
the sample, or passed over.

Sample containers shall be maintained \*  
under the control of the inspector, and \*  
where such control is not possible, \*  
samples shall be adequately secured. \*

#### 27.13 PRODUCT EXAMINATIONS; \* SAMPLE PREPARATION \*

During sample preparation and product \*  
examinations, inspectors must assure \*  
that samples are handled in a manner to \*  
maintain their wholesomeness and \*  
quality, as follows:

a. When inspectors observe question- \*  
able defects, detect unusual condi- \*  
tions, or suspect abnormal situations, \*  
they shall immediately contact super- \*  
vision for guidance.

b. Inspectors must assure that \*  
samples are under their control or \*  
adequately secured during preparation \*  
for product examination.

\* c. Inspectors shall use the sampling plans and defect criteria listed on the reverse side of MP Form 68 for:

- \* 1. Boneless manufacturing meats
- \* 2. Condition of container examination (metal, glass, flexible, or semi-rigid)
- \* 3. Canned or packaged product examination (solid mixed product)

\* Defect descriptions and classifications for these examinations are on the front of MP Form 68.

\* d. Inspectors shall use the sampling plans and defect criteria in:

- \* 1. Table 27.3 for red meat carcasses, sides, and quarters.
- \* 2. Table 27.4 for red meat wholesale cuts (insides, knuckles, hams, loins, etc.). For lamb, mutton, pork, and goat carcasses use Table 27.4 and proceed as follows: Select sample carcasses using random numbers contained in the inspection assignment.

\* The 12-pound sample unit will be an

estimated weight from either the fore, rack, loin, or hind section. The first 12-pound sample unit (section of carcass) will be randomly selected from either the fore, rack, loin or hind section. The second and additional sample units will continue in a rotation pattern. For example, if the starting point selected is the loin section, the sample unit from the next carcass would be a 12-pound sample unit from the hind section, the next sample unit would be from the fore section, etc.

- \* 3. Table 27.5 for red meat retail cuts (steaks, chops, roasts, etc.).
- \* 4. Table 27.6 for poultry carcasses (chickens, turkeys, etc.)

e. For products not previously or specifically described (i.e., pork feet, extracts of meat, etc.), inspectors shall examine them using acceptance criteria as required by regulations, procedures, or policies for domestic product:

TABLE 27.3

## SAMPLING PLANS FOR RED MEAT SIDES(\*)

LOT SIZE (IN SIDES)	STEP	SAMPLE SIZE (SIDES)	CRITICAL		MAJOR		TOTAL	
			ACC	REJ	ACC	REJ	ACC	REJ
100	-	3	1	2	4	5	12	13
250	1	4	1	3	3	7	12	17
	2	3	-	-	-	-	-	-
		7	—	2	3	8	9	24
500	1	7	1	5	4	10	18	28
	2	7	-	-	-	-	-	-
		14	—	4	5	14	15	45
500	1	10	1	6	6	13	18	37
	2	12	-	-	-	-	-	-
TOTAL		22	—	6	7	21	22	68
								69

(\*) USE CARCASS AQL PROCEDURES (DEFECT DESCRIPTIONS/CLASSIFICATIONS)  
IN MPI MANUAL, PART II

TABLE 27.4  
SAMPLING PLANS FOR RED MEAT WHOLESALE CUTS (\*)

LOT SIZE (IN POUNDS)	SAMPLE SIZE (12 LB) (UNIT/AREA)	CRITICAL		MAJOR		TOTAL	
		ACC	REJ	ACC	REJ	ACC	REJ
24,000	12	0	1	1	2	5	6
60,000	30	0	1	2	3	10	11
240,000	47	0	1	3	4	15	16
500,000	67	0	1	4	5	20	21
1,000,000	89	1	2	5	6	25	26
99,999,999	120	1	2	6	7	32	33

(\*) USE BONELESS MANUFACTURING MEAT PROCEDURES (DEFECT DESCRIPTIONS/CLASSIFICATIONS)

TABLE 27.5  
SAMPLING PLANS FOR RED MEAT RETAIL CUTS (\*)

LOT SIZE (IN POUNDS)	SAMPLE SIZE (12 LB)	CRITICAL		MAJOR		TOTAL	
		ACC	REJ	ACC	REJ	ACC	REJ
24,000	12	0	1	0	1	1	2
60,000	30	0	1	0	1	3	4
240,000	47	0	1	0	1	4	5
500,000	67	0	1	0	1	5	6
1,000,000	89	0	1	1	2	6	7
99,999,999	120	0	1	1	2	8	9

(\*) USE BONELESS MANUFACTURING MEAT DEFECT DESCRIPTIONS/CLASSIFICATIONS

TABLE 27.6  
SAMPLING PLAN FOR POULTRY CARCASSES (\*)

LOT SIZE (IN POUNDS)	SAMPLE SIZE (CARCASSES)	MAJOR		TOTAL	
		ACC	REJ	ACC	REJ
99,999,999	20	7	8	42	43

(\*) USE CARCASS AQL PROCEDURES (DEFECT DESCRIPTIONS/CLASSIFICATIONS) IN MPI  
DIRECTIVE 918.1

\* 27.14 CANNED PRODUCT SAMPLING

\* (a) Sample Selection

\* Enough shipping cartons must be randomly selected to obtain the required number of containers for the sample. Containers shall be randomly selected from the sample cartons using Table 27.7.

\* TABLE 27.7 - SAMPLE SELECTION

\* Containers in carton      Sample

* 5 or less	All
* 6 - 12	6
* 13 - 60	12
* 61 - 230	16
* 231 or more	24

\* If, by using Table 27.7, the number of shipping cartons in a lot is not sufficient for a full sample, the inspector shall select more samples from each carton. If the total number of containers in a lot is equal to or less than the required sample, the inspector shall examine the entire lot.

\* (b) Sample Size, MP Form 68

\* MP Form 68 shall be used to determine the required sample sizes and to report all examinations.

\* 27.15 LOT EXAMINATION

\* (a) Inspector Responsibility

\* If questionable defects are identified during lot examination, the inspector shall contact his or her immediate supervisor for guidance.

\* For shelf stable products packaged in flexible or semi-rigid containers, foreign establishments must have prior approval of their processing and production procedures. Therefore, the inspector, through his or her immediate supervisor, shall determine from Foreign Programs Division that the establishment has complied with requirements before initiating inspection of the product.

(b) Shelf Stable, Heat-Processed Product

Applies to meat and poultry products that are packed in hermetically sealed (airtight) containers and are intended to remain safe and stable at room temperature.

Condition-of-Container Examination. The inspector shall visually examine each container drawn for the sample using the defect criteria on MP Form 68.

The finding of a container exhibiting any one of the following conditions requires that the lot be retained and the procedures outlined in Part 27.16(e) be followed:

- |              |             |
|--------------|-------------|
| 1. Swell     | 5. Overfill |
| 2. Flipper   | 6. Leaking  |
| 3. Springer  | 7. Burst    |
| 4. Loose Tin |             |

Only sound, normal-appearing containers shall be returned to an accepted lot.

(c) Container Examination Procedures

(1) Metal containers. If the can has a paper label, examine the label for stains that may be evidence of leakage, rust, etc. Put slight pressure on one end and observe for any movement of either end. Repeat the procedure for the other end. Gently run a finger along all double seams to detect any defects. Visually examine the double seam(s), the side seam and any container score lines on easy-open and pull-top devices for defects, leakage, etc. Check the container code impression to ensure there is no metal fracture or stress.

(2) Glass containers. Examine jar surfaces for obvious defects or crooked caps, etc. Examine the exterior of the jar closures for food particles or foreign material. Place slight pressure on the center of the cap and observe for any movement that may be indicative of a swell, flipper, short vacuum, loose cap, etc. If the cap has

\* a safety button or flip panel, such  
 \* should also be checked to ensure proper  
 \* sealing.

\* (3) **Flexible containers.** All flexible  
 \* containers (pouches) must be packaged  
 \* in an immediate overcarton.  
 \* Remove each container from its over-  
 \* carton and observe for possible vacuum  
 \* loss, swelling delamination, and leakage.  
 \* Inspect each side of the container for cuts,  
 \* cracks, scratches, food material, punctures,  
 \* missing labels, foreign material, etc. Check  
 \* pouches for improper closure seals  
 \* (defined in section 27.1).

\* (4) **Semi-rigid containers.** Such  
 \* containers come in a variety of types  
 \* and sizes and are generally either  
 \* sealed as a conventional metal  
 \* container (double seam) or more  
 \* commonly by heat sealing. If the  
 \* container has a double seam, the  
 \* procedures in section 27.15(c)(1)  
 \* should be followed. If the container  
 \* is heat sealed, the seal area should be  
 \* examined for entrapped matter,  
 \* delamination, leakage, etc. The  
 \* containers should be examined for  
 \* punctures, cracks, etc. All semi-rigid  
 \* containers, like flexible containers,  
 \* must be packaged in an immediate  
 \* overcarton.

#### \* 27.16 PRODUCT EXAMINATION; INCUBATION.

##### \* (a) Product Examination.

\* It shall be conducted in accordance  
 \* with the sampling plan and defect  
 \* criteria provided on MP Form 68.  
 \* Examples of foreign matter found during  
 \* product examination that are considered  
 \* critical defects include glass  
 \* fragments, metal, wire and stones.  
 \* Other defects that should be noted  
 \* include off-odor and color, abnormal  
 \* product consistency, etc.

##### \* (b) Sample Incubation

\* Provided the lot has been found  
 \* acceptable on the condition of container  
 \* examination and product

examination, samples shall be incubated \*  
 for further assurance of container \*  
 integrity and the product's shelf \*  
 stability. The inspector shall place \*  
 the lot on hold and notify the regional \*  
 office when abnormal containers develop \*  
 during incubation.

1. Incubation samples shall consist of 24 units, randomly selected from the lot being examined.

2. Only sound, normal-appearing containers shall be selected for incubation.

#### (c) Incubation Procedures

1. Incubation of samples shall be consistent with current MPI regulations (§ 318.11(i)). For flexible and semi-rigid containers, a 20-day incubation period is required unless otherwise instructed by Foreign Programs Division.

2. If the incubator temperature drops below the minimum temperature specified in the MPI regulations, the temperature shall be readjusted and the incubation time extended for the time the samples were held at the lower temperature. Conversely, if the incubator temperature exceeds the maximum temperature specified in the regulations, the same procedure shall be followed. EXCEPTION! If the incubator temperature ever exceeds 103°F., the test shall be terminated, the samples removed, the incubator temperature returned to within the acceptance range, and new randomly selected samples incubated for the required number of days.

#### (d) Lot Release Before Completion of Incubation

All applicable inspection procedures, including incubation, must be accomplished before marks of inspection are applied and canned shelf stable product is determined to be acceptable and released.

#### (e) Handling of Abnormal Containers

All abnormal containers found during the condition of container examination,

\* and all containers that develop abnormalities during incubation shall be handled in the following manner by the inspector. (NOTE: Containers that develop apparent abnormalities during incubation should be allowed to adjust to room temperature before a final evaluation is made regarding containers condition.)

\* (1) Reporting procedures. When any abnormal containers are found, the inspector shall immediately inform the circuit supervisor. The inspector or supervisor shall then immediately contact, by telephone, the Microbiologist-in-Charge at the designated Multidisciplinary Laboratory (i.e., Athens, St. Louis or San Francisco), and the Regional Office so that Foreign Programs Division may be alerted. The following information shall be reported:

- \* 1. Name of the inspector, location and telephone number;
- \* 2. Foreign establishment number and name;
- \* 3. Product name, container type and size, and container code;
- \* 4. Where abnormals were found (i.e., incubator, condition of container examination, warehouse), a description of the defect(s) and the approximate number of abnormals.
- \* 5. Size of lot(s) under retention and whether there is any evidence of additional abnormals; and,
- \* 6. Any other pertinent information.

\* The inspector shall subsequently inform the broker of the actions taken.

\* (2) Submission of samples. The Microbiologist-in-Charge will provide instructions regarding submission of samples (e.g., number of abnormal and normal containers, method of shipment, etc.). The inspector shall immediately ship the laboratory samples with the

completed MP Form 6000-1. If for any reason samples cannot be shipped immediately, such should be placed under security and held under refrigeration (not frozen).

(3) Inspection of other lots. Subsequent lots of similar product from the same producer shall be inspected for any evidence of similar defects. If similar defects are found the lot shall be placed on hold and the regional office and Microbiologist-in-Charge notified.

(4) Disposition of retained product. The inspector will be informed, through supervisory channels, of the disposition of the product being held.

(f) Canned; Perishable  
Perishable "Keep Under Refrigeration" Canned Product applies to all meat products that are packed in hermetically sealed containers (airtight) and are intended to be kept refrigerated at all times.

(1) Condition of Container  
Examination. Such examination shall be consistent with the procedures provided for Shelf Stable, Heat-Processed Product (see section 27.15) and MP Form 68.

(2) Product Examination. Such examinations shall be consistent with the procedures provided for Shelf Stable Heat-Processed Product and MP Form 68. In addition, for solid-packed product such as canned hams and picnics, slab bacon, or other products primarily of a solid unit, the inspector shall observe all outer surfaces and make at least one cut through the product to check inner surfaces for defects, possible product discoloration indicative of underprocessing, etc. (Submission of samples to the laboratory for internal temperature is discussed in section 27.17(c)(2)).

- \* (3) Sample incubation. Not applicable for perishable products.
- \* must perform the "pink juice" test to \* detect possible under cooking (see \* section 27.2(c)(4)).
- \* (4) Handling of Abnormal Containers. The inspector shall follow the procedures provided for Shelf Stable, Heat-Processed Products.
- \* (5) Disposition of Retained Product. The inspector will be informed through supervisory channels regarding the disposition of any retained product.
- \* (g) Net Weight Net weight checks of imported product will be conducted as directed on the Inspection Assignment. Results of tests will be recorded on the MP Form 68.
- \* (h) Vignette, Declared Count During product examination of canned or packaged product, the inspector will also determine compliance of the label vignette and declared count, if applicable, following procedures described in sections 18.63 and 18.64 of the Manual.
- \* (i) Boneless Meat
  - (1) Boneless manufacturing meats shall be examined by using sampling plans and defect criteria listed on MP Form 68. All examinations will be recorded on the form. Examination will also be performed on frozen, bulk-packed wholesale cuts, boneless goat, boneless mutton, edible horsemeat, and cooked meat. When sampling bulk-packed, boneless wholesale cuts, the inspector shall select 24-pound sample units. The MP Form 68 does not list all of the boneless pork defects which appear in section 18.13, Chart 18.1-A. When non-listed defects are observed they will be entered under "other" code 331, and explained in the remarks column.
  - (2) When examining cooked meat from restricted countries, the inspector
- \* (3) Frozen sample units shall be completely defrosted for examination. Inspectors must be assured that the entire contents of a carton are subject to sampling. Sample units may be selected from the center or either end of the meat block and shall not be less than 2 inches thick. Defrosting may be accomplished by use of hot water, hot air, or natural means. Defrost procedures must prevent product contamination.
- \* (4) When defrost is accomplished by immersion in liquid the establishment shall supply high quality plastic bags or other acceptable means of preventing defrost liquid from contacting and adulterating the sample unit. If contact with defrost media occurs, the affected sample unit shall be condemned, and a new sample drawn from the same container as the original. The temperature of the defrost media shall not exceed 125°F., and shall not affect the appearance of the sample.
- (j) Sample Identification
  - Definite identification of sample units by respective lots will be maintained through all phases of sampling and inspection.
  - Inspectors must be sure that samples are under their control, or under official lock or seal at all times after selection and until the lot has been inspected and passed, or inspected and refused entry. Sample cartons traveling from the port of entry or warehouse to a defrost facility must be under direct visual control of the inspector or travel under official seal. The inspector must use codes that identifies the lot to identify each sample, and correlate each sample with the corresponding box. A procedure for selecting, transporting, securing samples, defrosting and inspection must be developed by the

\* inspector and approved by the circuit supervisor and kept on file at the establishment.

#### \* (k) Defects

\* During product examination, defects from passed lots shall be removed under the inspector's observations. Defects from rejected lots must be placed into a properly identified sample box and removed before the refused entry lot leaves the United States. Defects removed from accepted lots will be denatured and discarded when inspection is completed.

#### \* (l) Wholesale Cuts

\* Examine individually wrapped or separate pieces by using sampling plans and Table 27.4. Use defect type, description and classification outlined in section 18.13, Charts 18.1 or 18.1-A as applicable. The inspector shall examine a unit of approximately 12 pounds from each sample carton without cutting individual pieces. Examine frozen cuts only after sufficient tempering to remove frost or glaze and to allow the meat surfaces to determine product compliance and establish product history.

shipments are placed on "sample and hold" pending receipt of laboratory analytical results. If the Inspection Assignment is not specific concerning compliance history, additional information may be obtained from the computer terminal operator.

With the concurrence of the circuit supervisor, inspectors may override the Inspection Assignment and apply "sample and hold" criteria at any time there is reason to suspect noncompliance.

#### (b) General Procedures

See Part 23 for preparation of samples for chemical, microbiological, and special analytical requests, and section 11.18(f) for preparation of samples for residue analyses.

Inspectors will follow sampling instructions contained in the Inspection Assignment. Samples must be selected in a manner to assure that they are representative of the lot offered for entry.

Where feasible, laboratory samples should be selected from containers opened for product examination.

To provide an accurate record of lots sampled, the product name, production codes and all other identifying marks must be noted on the sample forms.

Samples must be maintained under the inspectors direct visual control or official lock or seal until delivered to the postal department or other carrier for shipment to official or certified laboratories. It is no longer necessary to delay mailing of samples to FSIS laboratories to avoid weekend delivery. Arrangements have been made to assure that samples arriving by mail on Saturdays, Sundays and holidays will be picked up by laboratory personnel.

If samples are shipped via carrier other than the postal department the receiving laboratory must be alerted to expect delivery.

#### (c) Specific Procedures

(1) Canned hams, loins, picnics, and similar pork products (Table 27.8).

a. Select samples as directed on the Inspection Assignment. Product

### \* 27.17 SAMPLING

#### \* (a) History

\* Unless a compliance history has been established, individual product

\* controlled by "normal or "skip lot" criteria need not be held pending laboratory results. However, if a Zone E result is received, retain the sampled lot if it is still on hand.

\* b. When the Inspection Assignment indicates that the lot is to be inspected and sampled under "tightened" criteria, submit approximately a 1-pound sample of a composite of 6 cans (submit 6 individual cans if a composite is not feasible). Hold the lot pending receipt of laboratory results and:

\* 1. Release the lot if the sample results are in Zone B, or lower.

\* 2. Refuse entry if the sample results are in Zone B, or higher.

\* c. Previously sampled lots refused entry because of sample results in Zone B, or higher may be further sampled, at the importer's request, by random selection of 30 additional single cans from the lot.

\* Release the product if:

immediately notify the computer terminal operator. The results will be entered in the AIIS, and the establishment's product compliance history will be adjusted accordingly.

e. Additional laboratory analyses requested by the importer as described in paragraph (iii) above, will be performed by a certified laboratory at the importer's expense.

**(2) Canned Perishable Pork Product.**

a. When underprocessing of canned perishable pork products is suspected, submit samples for internal temperature determination. Place the suspect lot under retention until laboratory analysis is received.

b. When samples of product from VS. restricted countries indicate underprocessing, inspectors shall immediately contact the PPQ officer in charge at the port of entry for

TABLE 27.8

## CANNED PORK SAMPLE LIMITS

Zone	Hams, Loins Similar Pork Products	Picnics
A	108.0 or Less	108.0 or Less
B	108.1 - 110.4	108.1 - 109.5
B <sub>1</sub>	110.5 - 110.8	109.5 - 109.8
C	110.9 - 113.5	109.9 - 111.6
D	113.6 - 116.2	111.7 - 113.5
E	116.3 - Over	113.6 - Over

\* 1. The average of the 30 samples does not exceed Zone A and;

\* 2. None of the individual results are in Zone E.

\* d. Upon receipt of laboratory results for product sampled as described above, inspectors will

notification to VS. Inspectors will also notify the computer terminal operator.

**(3) Moisture Protein Ratio (MPR).**

Table 27.9 establishes decision zones for moisture protein ratios of certain imported produce.

- \* a. Select samples as directed on the Inspection Assignment. Product controlled by "skip lot" criteria need not be held pending laboratory results.
  - \* b. When the Inspection Assignment indicates the lot is to be inspected and sampled under tightened criteria, retain the lot pending receipt of laboratory results and:
    1. Release the lot if the sample result is in Zone A or lower.
    2. Refuse entry if the sample result is in Zones B<sub>1</sub> or C.
  - \* c. Previously sampled lots refused entry because of laboratory results in Zone B<sub>1</sub> may be further sampled, at the importer's request, by random selection of 6 additional samples from the lot. Release the product if:
    1. The average of the 6 samples does not exceed Zone A and;
    2. None of the individual results are in Zone C or higher.
  - \* d. Previously sampled lots refused entry because of results in Zone C may be further sampled, at the importers request, by random selection of 30 additional samples from the lot. Release the product if:
    1. The average of the 30 samples does not exceed Zone A and;
    2. None of the individual results are in Zone C or higher.
  - \* e. Upon receipt of laboratory results for product sampled as described above, inspectors will immediately notify the computer terminal operator. The results will be entered into the AIIS, and the establishment's product compliance history will be adjusted accordingly.
  - \* f. Additional laboratory analyses requested by the importer as described above, will be performed by a certified laboratory at the importer's expense.
- \* (4) Species Sampling. Species sampling will be automatically assigned by the AIIS. When the Inspection Assignment calls for a species sample, the inspector will:
1. Use MP Form 6000-1.
  2. Note on the Form "Import Species Monitoring Program."
  3. Select a 4 oz. piece of meat (100 grams) from any box assigned by AIIS random numbers for sample selection.
  4. Send species samples to the Microbiological Laboratory assigned to the State as listed in the Meat and Poultry Inspection Directory.
  5. Inform Foreign Programs Division of any problem encountered.
- In addition to species sampling directed by the Inspection Assignment, inspectors will submit samples for analysis at any time they have reason to suspect product species. When this is done, follow procedures outlined above and retain the lot pending receipt of laboratory results. Note the following on the MP Form 6000-1; "Inspector Initiated" - "Product Held" - "Region Notified."

#### (d) Receipt for Laboratory Samples

Inspectors will complete MP Form 64 whenever samples are collected for laboratory examination. Give the original to the importer and attach the duplicate to the original copy of the MP Form 410 which is forwarded to the computer terminal operator.

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#### DISPOSITION

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#### Subpart 27-D

(Regs: M-317; 327 P-Subpart L, T)

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Disposition of imported product is based upon compliance with MPI and other governmental Agency requirements.

TABLE 27.9

## MOISTURE PROTEIN RATIO

Product	Zone A	Zone B	Zone C
Beef/Mutton Corned Canned	2.28:1	2.29:1 - 2.34:1	2.35:1
Beef Dried (Chipped)	2.04:1	2.05:1 - 2.10:1	2.11:1
Jerky/Pemmican	0.75:1	0.76:1	0.77:1
Roast (Parboiled)			
Steam Roasted Canned)	2.25:1	2.26:1 - 2.31:1	2.32:1
Sausage Air Dried	2.10:1	2.11:1 - 2.15:1	2.16:1
Dry Fermented (Except Genoa)	1.90:1	1.91:1 - 1.96:1	1.97:1
Genoa Salami	2.30:1	2.31:1 - 2.36:1	2.37:1
Canned Mortad- ella	3.85:1	3.86:1 - 4.04:1	4.05:1
Pepperoni	1.60:1	1.61:1 - 1.65:1	1.66:1
Meat Broth/ Stock Concentrated	67:1	N/A	N/A
Regular	135:1	N/A	N/A

**\* 27.18 NONINSPECTED PRODUCT**

\* Information relative to imported  
 \* product not presented for inspection  
 \* within 30 days shall be reported to the  
 \* regional office.

**\* 27.19 MP FORM 410****(a) Completion**

\* Section E of the MP Form 410 shall  
 \* be completed, signed and dated by the  
 \* inspector upon completion of the  
 \* examination. Note: Inspection is not

considered complete when lots are on \*  
 hold pending receipt of sample results, \*  
 or are under active appeal! When a lot \*  
 or portion of a lot is refused entry, \*  
 the inspector will identify amounts, \*  
 rejection codes, and disposition. \*

**(b) Codes**

Inspectors shall assure that correct \*  
 country, product, and where applicable, \*

- \* rejection codes are entered on the MP Form 410 and other applicable documents to the computer terminal operator on the day inspection is completed.
- \* (1) Country codes. See Table 27.1.
- \* (2) Product codes. Use the code listed on the Inspection Assignment. If there is a question concerning the accuracy of a product code, contact the computer terminal operator.
- \* (3) Rejection codes. See Table 27.10.
- \* (c) Distribution
  - \* When lots are inspected and passed the inspector shall forward the MP Form 410 and other applicable documents to the computer terminal operator on the day inspection is completed.
  - \* When lots are inspected and refused entry, the inspector shall immediately complete the following forms and send a copy of each to the computer terminal operator, U.S. Customs, and Foreign Programs Division:
    1. MP 410
    2. MP 63
    3. MP 68
    4. Health Certificate
    5. Customs Form 4613 (if product is to be destroyed)
    6. Customs Form 3499 (if product is to be converted to nonhuman use)

Table 27.10 - Rejection codes

Rejection cause	Code
Contamination (dirt, hair, feces, ingesta, etc.)	01
Processing defects (bones, bruises, clots, etc.)	02
Unsound condition	03
Pathological defects	05
Labeling defects	07
Composition/standard	09
VS requirements	10
Residues	11
Miscellaneous	12
Container condition (defects)	13

\* **27.20 Passed Lots; Marking**

\* No shipping container, carcass, or  
 \* individually shipped part shall be  
 \* stamped with the "U.S. Inspected and  
 \* Passed" import brand before completion  
 \* of inspection.

\* Containers of horsemeat shall have  
 \* the word "horsemeat" in letters not  
 \* less than  $\frac{1}{2}$  inch high. The appropriate  
 \* hexagonal brand described in  
 \* section 312.7(a) of the MPI regulations  
 \* shall be stamped in green ink adjacent  
 \* to such wording.

\* Inspected and passed imported product  
 \* is considered to be domestic product.  
 \* If it is later found to be suspicious  
 \* or unacceptable, it shall be retained  
 \* and the regional office contacted for  
 \* disposition instructions. Additionally,  
 \* such product located outside of  
 \* official establishments shall be re-  
 \* ported to the Compliance Division for  
 \* appropriate action.

\* Sampling may often result in certain  
 \* amounts of unmarked product left over  
 \* from accepted lots. Such product is  
 \* usually given away to charitable  
 \* organizations or to importer's  
 \* employees. However, if requested, it  
 \* may be shipped to a local official  
 \* establishment for further processing  
 \* provided it is acceptably packaged and  
 \* properly identified as to contents and  
 \* country of origin. Product from lots  
 \* being held pending laboratory or  
 \* incubation results shall not be shipped  
 \* or given away until favorable results  
 \* are received.

\* **27.21 REJECTED SHIPMENT**

\* **(a) Identification**

\* Rejected lots shall be clearly  
 \* identified as "U.S. Refused Entry."  
 \* This shall be done in such a manner as  
 \* to assure that the identity of the  
 \* product as "U.S. Refused Entry" is  
 \* highly visible from any angle of  
 \* approach. For example, if the product  
 \* is palletized or in combo-bins, the  
 \* "U.S. Refused Entry" placard shall be  
 \* placed on all four sides of the pallet  
 \* or combo-bin.

\* Inspectors shall inform importers  
 \* that rejected shipments shall be

disposed of within 45 calendar days of \*  
 completion of inspection. In extreme \*  
 situations, such as dock workers' \*  
 strikes or vessel delays, the importer \*  
 may submit a written request to the \*  
 Administrator requesting an extension. \*  
 Such request must specify reason for \*  
 delay.

The owner of refused entry product \*  
 shall not transfer legal title of such \*  
 product. However, the title to product \*  
 intended for export may be transferred \*  
 to a foreign consignee, and the title \*  
 to product intended for destruction for \*  
 human food purposes may be transferred \*  
 to end user, e.g., a pet food \*  
 manufacturer or renderer.

**(b) Shipping Under Seal**

To be exported, product which has  
 been refused entry at destination \*  
 inspection locations shall be trans- \*  
 ported to a port approved by the \*  
 Agency under official seal; product \*  
 refused entry at port inspection loca- \*  
 tions must be exported from that port. \*  
**EXCEPTION!** If exportation to a \*  
 country willing to receive the refused \*  
 entry product is not feasible from the \*  
 port inspection location, the importer \*  
 may submit a written request to the \*  
 Regional Director for permission to \*  
 transport the product under official \*  
 seal to a port approved by the Agency. \*  
 Such requests shall be accompanied by \*  
 a completed Customs Form 7512 and con- \*  
 tain the following information:

1. MP 410 number
  2. Customs entry number
  3. Originating country and \*  
establishment number
  4. Number of containers and weight \*
  5. Date and reason for refusal \*
  6. U.S. port of destination \*
  7. Consignee and destination country \*
  8. Proof that export arrangements \*
- have been made

The original 45 day time limit is \*  
 still applicable under this exception. \*  
 The import inspection office must \*  
 complete MP Form 408 and submit it with \*  
 a copy of Customs Form 7512 to the port \*

**(c) Notification**

In all refused entry cases the MPI inspector shall immediately notify the following parties (directly or by telephone) of the essential details of the refused entry being reported:

1. Circuit Supervisor
2. Customs at the point of inspection

3. Importer/broker

4. Automated Import Information System (AIIS) Terminal Operator where the MP Form 410 was entered

Foreign Programs Division (FPD) will notify inspection officials in the country of origin that product has been found unacceptable.

A Copy of Customs Form 7512, indicating the name of the foreign country to which the refused entry product is consigned will be immediately forwarded to FPD. FPD will furnish information to the U.S. Embassy in the receiving country for transmittal to that government's health officials.

**(d) Product Disposal**

**(1) Defective Portions.** See section 27.10. Defective or damaged product may be removed from the lot and refused entry without formal sampling or presented as a separate lot for formal sampling.

**(2) Direct Supervision.** Inspectors will directly supervise the destruction or denaturing of refused product. Transportation of refused product for destruction, denaturing, or exportation shall be accomplished under official seal. If refused product is to be exported, inspectors will directly observe product being loaded aboard vessel or carrier, and notate such action on the MP Form 410 and, if available, the Customs Form 7512.

**(3) Reimbursable Charges.** Reimbursable charges for activities outlined in (2) above occurring during the inspectors' base time will not be imposed as long as the supervision of these activities does not interfere

with, or detract from, the inspector's normal duties. When requested to supervise the destruction, denaturing, or exportation, of refused product, inspectors shall first contact their circuit supervisor for authorization, and notify the requestor whether or not the activity will be conducted on a reimbursable fee basis.

**(e) Animal Food**

**(1) Application.** Refused entry product shall not be used in the manufacture of certified animal food. To direct product to other animal food channels with U.S. Customs and FDA permission, the importers shall apply in writing to the regional director identifying cause of rejection, intended destination, Consignee, and date to be shipped (diverted). Such product shall be used within 45 calendar days after rejection.

**(2) Denaturing.** See procedures outlined in Section 325.13 and 381.95 of the meat and poultry inspection regulations, and section 27.4(e) of the manual. When refused entry product has been destroyed or denatured, the inspector supervising such action shall contact the computer terminal operator so that the Customs office at the original port of entry may be notified and the case file closed.

**(f) Product Reconditioning**

Inspectors shall not permit reconditioning of refused product unless authorized by the regional office. Sorting or reconditioning of refused product is a privilege. Regional offices will grant the privilege only once for any shipment, and the sorting or reconditioning may be accomplished only by competent personnel under the inspector's supervision. When the reconditioning consists of relabeling, it shall be conducted under identification service.

**(g) Exportation**

Refused entry product must be exported within 45 days after inspec-

\* tion. Extensions may be granted by  
\* the Administrator or his designee.

\* (1) Export Package. The importer/  
\* broker must complete and submit a  
\* Customs Form 7512 package for all  
\* refused entry product to be exported.  
\* The package must include two addi-  
\* tional copies of Customs Form 7512.  
\* One copy must be conspicuously marked  
\* "MPI Copy" and identified with a piece  
\* of red tape. The other copy must be  
\* marked "Classification and Value  
\* Copy". The importer/broker must also  
\* provide a stamped envelope addressed  
\* to the appropriate computer terminal  
\* operator.

\* The importer/broker must first submit  
\* the Customs Form 7512 package to the  
\* computer terminal operator where the  
\* MP 410 number is entered into MPI's  
\* computer system. The Terminal Operator  
\* will review the package for  
\* completeness. The package must  
\* include:

- \* 1. MPI copy of 7512 as identified  
\* above.
- \* 2. A stamped addressed envelope.
- \* 3. The MP Form 410 number in the  
\* body of the 7512 and confirmation that  
\* the MP 410 was entered through their  
\* terminal.
- \* 4. Classification and Value Copy as  
\* identified above.
- \* 5. A photo copy of the 7512 for  
\* immediate transferral to Foreign  
\* Programs.

\* (2) Certification of Export. If the  
\* package is in order the terminal  
\* operator shall:

- \* a. Stamp all copies of the Customs  
\* Form 7512 in red ink "Restricted  
\* Product," "U.S. Refused Entry," "No  
\* Subdivision or Diversion", and the  
\* Terminal Operator's office address  
\* stamp and actual calendar date by which  
\* product must be exported.
- \* b. Return the package to the  
\* importer/broker.

\* The importer/broker must then submit  
\* the Custom Form 7512 package to the  
\* appropriate Customs office.

\* At the time of loading the refused  
\* entry product for exportation, Customs

will mail the certified MPI copy of the \*  
Custom Form 7512 in the preaddressed \*  
envelope to the appropriate Terminal \*  
Operator's office. \*

#### (h) Failure to Export or Destroy \*

Inspection Operations will notify \*  
the Foreign Programs Division and \*  
Compliance Division when refused entry \*  
products have not been properly \*  
disposed of. \*

Whenever the owner fails to have \*  
refused entry product exported, \*  
converted to animal food, or otherwise \*  
destroyed within the fixed time period, \*  
the Compliance Division will initiate \*  
legal action to destroy the product for \*  
human food purposes. \*

### 27.22 RETURN OF EXPORTED PRODUCT\*

#### (a) Regulatory Provisions \*

Sections 327.17 and 381.209 of the \*  
MPI regulations provide that returned \*  
U.S. exported product may enter the \*  
United States upon approval of the \*  
Administrator of the FSIS or the Deputy \*  
Administrator of MPIO. \*

At the point of entry (POE) where \*  
import inspectors are assigned, the \*  
circuit supervisor will discuss the MPI \*  
requirements for returned meat and \*  
poultry products with U.S. Customs \*  
officials assigned to the same POE. At \*  
the POE where an import inspector is \*  
not assigned, the area supervisor will \*  
contact the local U.S. Customs \*  
officials and discuss such require- \*  
ments. Where possible, MPI will offer \*  
U.S. Customs assistance; i.e., forms, \*  
seals, etc., to secure shipments for \*  
movement to locations where MPI per- \*  
sonnel are assigned. MP Form 410 \*  
shall not be used for returned product. \*

#### (b) Shipment Examinations \*

Upon notification of a returned \*  
shipment, MPI personnel shall examine \*  
the product to determine if it has \*  
become adulterated or misbranded during \*  
transit. Adulterated or misbranded \*  
product will be condemned, or if \*  
possible, reconditioned under MPI \*  
supervision at POE or an official \*

\* establishment. Product not eligible  
\* for free movement shall be transferred  
\* under official seal and MP Form 408.

**\* (c) PPQ/VS Requirements**

\* PPQ/VS clearance must be assured for  
\* each shipment before it may be allowed  
\* to move away from its POE.

**\* (d) Compliance Division**

\* Whenever the owner or representative  
\* of returned product disagrees with the  
\* MPI disposition made on product not in  
\* an official establishment, MPI  
\* Personnel shall request U.S. Customs  
\* officials to hold the shipment in  
\* question until further notified and  
\* will immediately contact the  
\* Compliance Division.

UNITED STATES DEPARTMENT OF AGRICULTURE  
Food Safety and Inspection Service  
Meat and Poultry Inspection  
Washington, DC 20250

MEAT AND POULTRY INSPECTION REGULATIONS

Date: December 1982 Change Number: 82-12

MAINTENANCE INSTRUCTIONS

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Remove Page

Insert Page (Numbered 82-12 )

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SUBCHAPTER A - MEAT INSPECTION REGULATIONS

93 and 94.....	93 and 94
121, 121a, and 122 .....	121, 122, and 122a *
140a and 140b .....	140a and 140b **

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SUBCHPATER C - POULTRY INSPECTION REGULATIONS

69 and 70 .....	69 and 70
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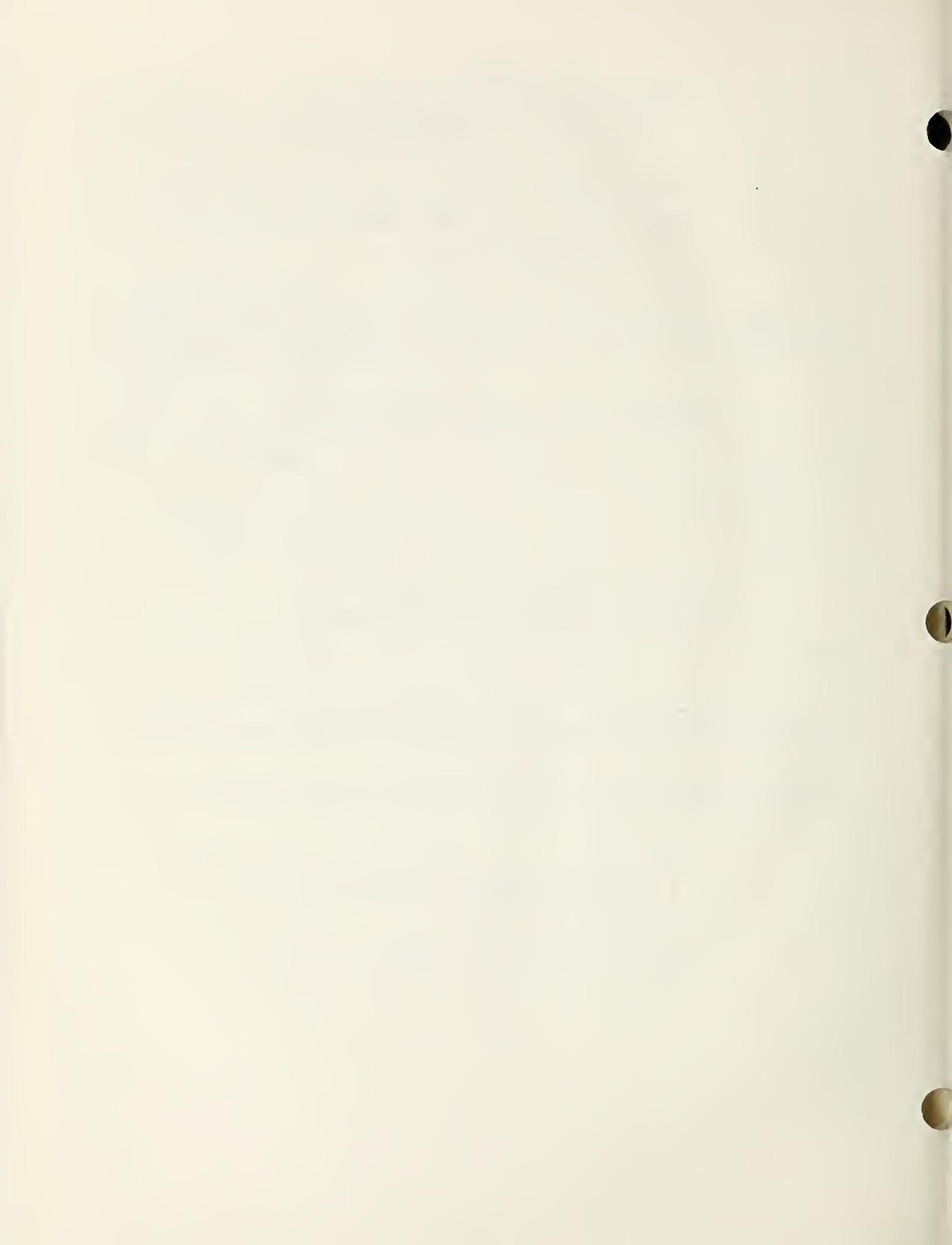
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\* Reprinted with new page numbers to comply with new departmental guidelines.  
No revisions of content have been made.

\*\* Revised to include note (inadvertently omitted in 1981) pertaining to  
effective date of certain provisions.

The effective date of this regulation  
change is as follows:

Reporting of Obsolete Labels: 1/3/83



**§ 317.13 Storage and distribution of labels and containers bearing official marks.**

Labels, wrappers, and containers bearing any official marks, with or without the establishment number, may be transported from one official establishment to any other official establishment provided such shipments are made with the prior authorization of the inspector in charge at point of origin, who will notify the inspector in charge at destination concerning the date of shipment, quantity, and type of labeling material involved. No such material shall be used at the establishment to which it is shipped unless such use conforms with the requirements of this subchapter.

§ 317.14 Reporting of obsolete labels.

- \* Upon notification from the plant management of an official establishment that  
\* a label is no longer in use, or upon notification from the Standards and  
\* Labeling Division that a label is no longer approved, the inspector at the  
\* official establishment shall remove the label and accompanying transmittal  
\* sheet from the official file. The inspector shall return the label to the  
\* plant management. Additionally, the inspector shall forward the transmittal  
\* sheet which bears the official approval number to the Standards and Labeling  
\* Division for data recording. Before forwarding the transmittal sheet, the  
\* inspector shall identify the sheet with the date and the word "rescinded".

§ 317.15 [Reserved]

**§ 317.16 Labeling and containers of custom prepared products.**

Products that are custom prepared under § 303.1(a)(2) of this subchapter must be packaged immediately after preparation and must be labeled (in lieu of information otherwise required by this Part 317) with the words "Not for Sale" in lettering not less than three-eighth inch in height. Such exempted custom prepared products or their containers may bear additional labeling provided such labeling is not false or misleading.

**§ 317.17 Interpretation and statement of labeling policy for cured products; special labeling requirements concerning nitrate and nitrite.**

(a) With respect to sections 1(n), (7), (9), and (12) of the Act and § 317.2, any substance mixed with another substance to cure a product must be identified in the ingredients statement on the label of such product. For example, curing mixtures composed of such ingredients as water, salt, sugar, sodium phosphate, sodium nitrate, and sodium nitrite or other permitted substances which are added to any product, must be identified on the label of the product by listing each such ingredient in accordance with the provisions of § 317.2.

(b) Any product, such as bacon or pepperoni, which is required to be labeled by a common or usual name or descriptive name in accordance with § 317.2(c)(1) of this Part and to which nitrate or nitrite is permitted or required to be added may be prepared without nitrate or nitrite and labeled with such common or usual name or descriptive name when immediately preceded with the term "Uncured" as part of the product name in the same size and style of lettering as the product name, provided that the product is found by the Administrator to be similar in size, flavor, consistency, and general

(§ 317.17(b) continued)

appearance to such product as commonly prepared with nitrate or nitrite, or both.

(c) (1) Products described in paragraph (b) of this section or § 319.2 of this subchapter, which contain no nitrate or nitrite shall bear the statement "No Nitrate or Nitrite Added." This statement shall be adjacent to the product name in lettering of easily readable style and at least one-half the size of the product name.

(2) Products described in paragraph (b) of this section and § 319.2 of this subchapter shall bear, adjacent to the product name in lettering of easily readable style and at least one-half the size of the product name, the statement "Not Preserved-Keep Refrigerated Below 40° F. At All Times" unless they have been thermally processed to F<sub>o</sub> 3 or more; they have been fermented or pickled to pH of 4.6 or less; or they have been dried to a water activity of 0.92 or less.

(3) Products described in paragraph (b) of this section and § 319.2 of this subchapter shall not be subject to the labeling requirements of paragraphs (b) and (c) of this section if they contain an amount of salt sufficient to achieve a brine concentration of 10 percent or more.

§ 317.18 [Reserved]

§ 317.19 Jar closures requirements.

Vacuum packed containers sealed with quick-twist, screw-on, or snap-on lids (or closures) shall not have an annular space between the inner edge of the lid's rim (lip or skirt) and the container itself or shall have such space sealed in a manner that will make it inaccessible to filth and insects.

#### PART 318-ENTRY INTO OFFICIAL ESTABLISHMENTS: REINSPECTION AND PREPARATION OF PRODUCTS

AUTHORITY: The provisions of this Part 318 issued under sec. 21, Federal Meat Inspection Act, as amended by the Wholesome Meat Act (21 U.S.C. Supp., sec. 601 et seq.), and Public Law 91-342; Talmadge-Aiken Act of Sept. 28, 1962, (7 U.S.C. 450); Act of July 24, 1919, (7 U.S.C. 394); subsection 21(b), Federal Water Pollution Control Act, as amended by Public Law 91-224 and by other laws.

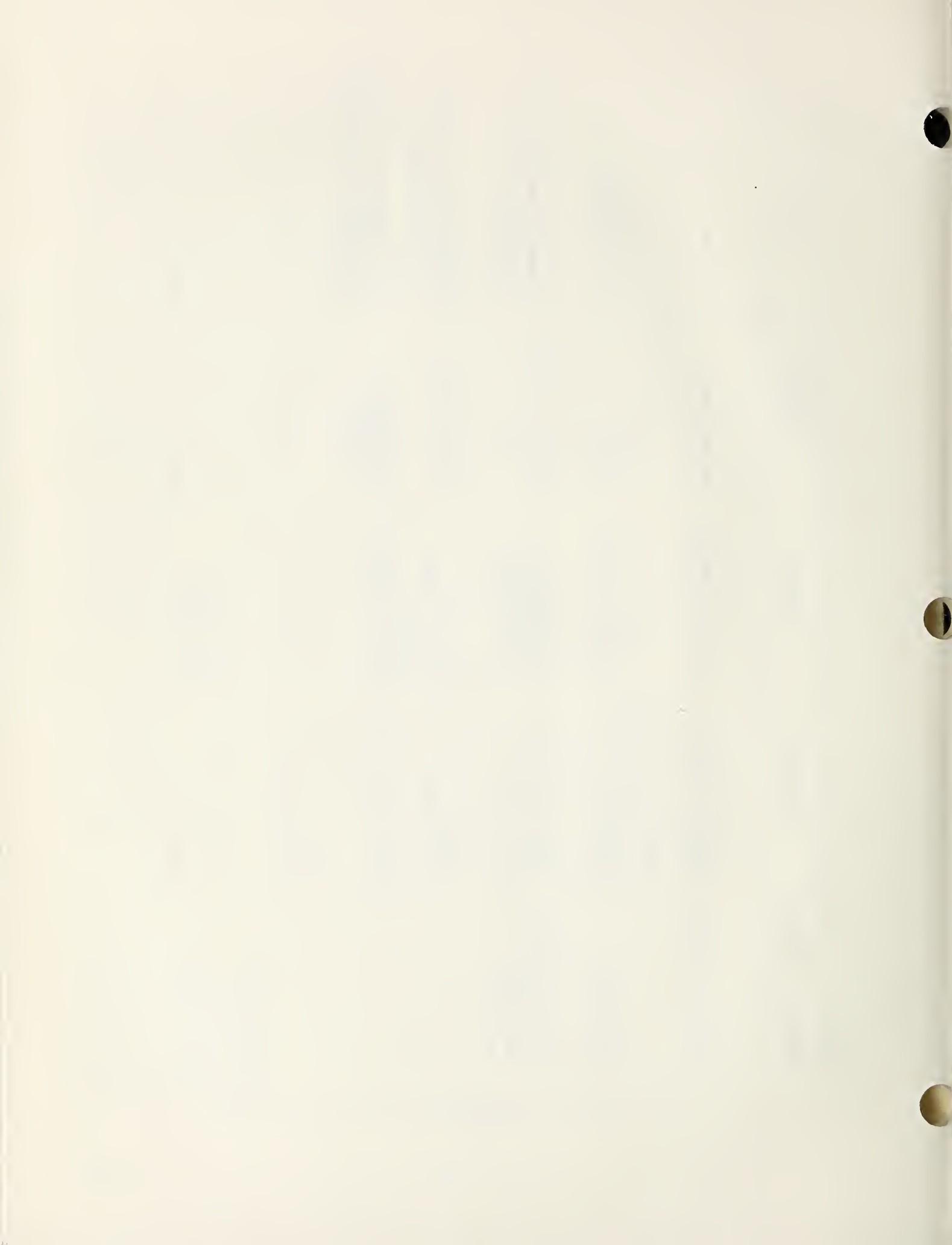
§ 318.1 Products and other articles entering official establishments.

(a) Except as otherwise provided in paragraphs (g) and (h) of this section or § 318.12, no product shall be brought into an official establishment unless it has been prepared only in an official establishment and previously inspected and passed by a Program employee, and is identified by an official inspection legend as so inspected and passed. Notwithstanding the foregoing provisions of this subparagraph, product imported in accordance with Part 327 of this subchapter and not prepared in the United States outside an official establishment, may enter any official establishment subject in other respects to the same restrictions as apply to domestic product. Products received in an official establishment during the Program employee absence shall be identified and maintained in a manner acceptable to such employee. Product entering any official establishment shall not be

Class of substance	Substance	Purpose	Products	Amount
* * *	Sodium acid pyro-phosphate.	do	do	do.
* * *	Dipotassium phosphate.	do	do	do.
* * *	Monopotassium phosphate.	do	do	do.
* * *	Potassium tripoly-phosphate.	do	do	do.
* * *	Potassium pyrophosphate.	do	do	do.
Proteolytic enzymes.	Aspergillus oryzae.	To soften tissues.	Raw meat cuts.	Solutions consisting of water and approved proteolytic enzymes applied or injected into raw meat cuts shall not result in a gain or more than 3 percent above the weight of the untreated product.
	Bromelin.	do	do	do.
	Ficin.	do	do	do.
	Papain.	do	do	do.

Class of substance	Substance	Purpose	Products	Amount
Refining agents (must be eliminated during process of manufacturing).	Acetic acid.	To separate fatty acids and glycerol.	Rendered fats.	Sufficient for purpose.
	Bicarbonate of soda.	do	do	do.
	Carbon (purified charcoal).	To aid in refining of animal fats.	do	do.
	Caustic soda (sodium hydroxide).	To refine fats.	do	do.
	Diatomaceous earth; Fuller's earth.	do	do	do.
	Sodium carbonate.	do	do	do.
	Tannic acid.	do	do	do.

Class of substance	Substance	Purpose	Products	Amount
Rendering agents.	Tricalcium phosphate.	To aid rendering.	Animal fats.	do.
	Trisodium phosphate.	do	do	do.
Artificial sweeteners.	Saccharin.	To sweeten product.	Bacon.	0.01 percent.
Synergists (used in combination with antioxidants).	Citric acid.	To increase effectiveness of antioxidants.	Lard and shortening.	0.01 percent alone or in combination with anti-oxidants in lard or shortening.
			Dry sausage.	0.003 percent in dry sausage in combination with anti-oxidants.
			Fresh pork sausage.	0.01 percent on basis of fat content, in combination with anti-oxidants.



(§ 319.105 continued)

- (4) Hydrolyzed plant protein;
- (5) Corn syrup solids, corn syrup and glucose syrup, singly or in combination, in an amount not to exceed 2 percent (calculated on a dry basis) of all the ingredients used in preparing the chopped ham;
- (6) Disodium phosphate, sodium hexametaphosphate, sodium tripolyphosphate, sodium pyrophosphate, and sodium acid pyrophosphate, singly or in combination, in an amount not to exceed that permitted in § 318.7(c)(4) of this subchapter;
- (7) Ascorbic acid, sodium ascorbate, isoascorbic acid or sodium isoascorbate in an amount not to exceed that permitted in § 318.7(c)(4) of this subchapter;
- (8) Dehydrated onions or onion powder;
- (9) Dehydrated garlic or garlic powder.
- (10) Mechanically Separated (Species) used in accordance with § 319.6.

§ 319.106 "Country Ham," "Country Style Ham," "Dry Cured Ham," "Country Pork Shoulder," "Country Style Pork Shoulder," and "Dry Cured Pork Shoulder."

(a) "Country Ham," "Country Style Ham," or "Dry Cured Ham," and "Country Pork Shoulder," "Country Style Pork Shoulder," or "Dry Cured Pork Shoulder," are the uncooked, cured, dried, smoked or unsmoked meat food products made respectively from a single piece of meat conforming to the definition of "ham," as specified in § 317.8(b)(13) of this subchapter, or from a single piece of meat from a pork shoulder. They are prepared in accordance with paragraph (c) of this section by the dry application of salt (NaCl), or by the dry application of salt (NaCl) and one or more of the optional ingredients as specified in paragraph (d) of this section. They may not be injected with curing solutions nor placed in curing solutions.

(b) The product must be treated for the destruction of possible live trichinae in accordance with such methods as may be approved by the Administrator upon request in specific instances and none of the provisions of this standard can be interpreted as discharging trichinae treatment requirements.

(c)(1) The entire exterior of the ham or pork shoulder shall be coated by the dry application of salt or by the dry application of salt combined with other ingredients as permitted in paragraph (d) of this section.

(2) Additional salt, or salt mixed with other permitted ingredients, may be reapplied to the product as necessary to insure complete penetration.

(3) When sodium or potassium nitrate, or sodium or potassium nitrite, or a combination thereof, is used, the application of salt shall be in sufficient quantity to insure that the finished product has an internal salt content of at least 4 percent.

(4) When no sodium nitrate, potassium nitrate, sodium nitrite, potassium nitrite or a combination thereof is used, the application of salt shall be in sufficient quantity to insure that the finished product has a brine concentration of not less than 10 percent or a water activity of not more than 0.92.

(5) For hams or pork shoulders labeled "country" or "country style," the combined period for curing and salt equalization shall not be less than 45 days for hams, and shall not be less than 25 days for pork shoulders; the total time for curing, salt equalization, and drying shall not be less than 70 days for hams, and shall not be less than 50 days for pork shoulders. During the drying and smoking period, the internal temperature of the product must not exceed

(§ 319.106(c)(5) continued)

95°F, provided that such temperature requirement shall not apply to product dried or smoked under natural climatic conditions.

(6) For hams or pork shoulders labeled "dry cured," the combined period for curing and salt equalization shall not be less than 45 days for hams, and shall not be less than 25 days for pork shoulders; and the total time for curing, salt equalization, and drying shall not be less than 55 days for hams and shall not be less than 40 days for pork shoulders.

(7) The weight of the finished hams and pork shoulders covered in this section shall be at least 18 percent less than the fresh uncured weight of the article.

(d) The optional ingredients for products covered in this section are:

(1) Nutritive sweeteners, spices, seasonings and flavorings.

(2) Sodium or potassium nitrate and sodium or potassium nitrite if used as prescribed in this section and in accordance with § 318.7(c)(4) of this subchapter.

\* NOTE: \*

\* On January 6, 1981, FSIS announced that the temperature and time period provisions of § 319.106(c)(5) and (c)(6) have not been in effect since \*  
\* November 17, 1980, and will not be enforced pending future Agency action in \*  
\* the matter. However, ham and pork shoulders must continue to be prepared \*  
\* in compliance with all other provisions in § 319.106 in order to be labeled \*  
\* "country ham," "country style ham," or "dry cured ham," and "country pork \*  
\* shoulder," "country style pork shoulder," or "dry cured pork shoulder." \*

#### Subpart E-Sausage Generally: Fresh Sausage

##### § 319.140 Sausage.

Except as otherwise provided in this section, or under the Poultry Products Inspection Act with respect to products consisting partly of poultry,

(§ 381.138(b) continued)

involved. Approved labeling and containers may be moved without restriction under this part between official establishments operated by the same person if such labeling and containers are approved for use at all such establishments. No such material shall be used at the establishment to which it is shipped unless such use conforms with the requirements of this subpart.

§ 381.139 Removal of official identifications.

(a) Every person who receives any poultry product in containers which bear any official inspection legend shall remove or deface such legend or destroy the containers upon removal of such articles from the containers.

(b) No person shall alter, detach, deface, or destroy any official identifications prescribed in Subpart M that were applied pursuant to the regulations, unless he is authorized to do so by an inspector or this section; and no person shall fail to use any such official identification when required by this part.

§ 381.140 Relabeling poultry products.

When it is claimed by the operator of an official establishment that some of its labeled poultry product, which has been transported to a location other than an official establishment, is in need of relabeling because the labeling has become mutilated or damaged, or for some other reason needs relabeling, the requests for relabeling the poultry product shall be sent to the Administrator and accompanied with a statement of the reasons therefor and the quantity of labeling required. Labeling material intended for relabeling inspected and passed product shall not be transported from an official establishment until permission has been received from the Administrator. The relabeling of inspected and passed product with official labels shall be done under the supervision of an inspector pursuant to the regulations in Part 362 of this chapter. The establishment shall reimburse the Inspection Service for any cost involved in supervising the relabeling of such product as provided in said regulations.

§ 381.141 Reporting of obsolete labels.

\* Upon notification from the plant management of an official establishment that a label is no longer in use, or upon notification from the Standards and Labeling Division that a label is no longer approved, the inspector at the official establishment shall remove the label and accompanying transmittal sheet from the official file. The inspector shall return the label to the plant management. Additionally, the inspector shall forward the transmittal sheet which bears the official approval number to the Standards and Labeling Division for data recording. Before forwarding the transmittal sheet, the inspector shall identify the sheet with the date and the word "rescinded". \*

§ 381.143 Jar closures requirements.

Vacuum packed containers sealed with quick-twist, screw-on, or snap-on lids (or closures) shall not have an annular space between the inner edge of the lid's rim (lip or skirt) and the container itself or shall have such space sealed in a manner that will make it inaccessible to filth and insects.

Subpart O-Entry of Articles Into Official Establishments;  
Processing Inspection and Other Reinspections;  
Processing Requirements

§ 381.145 Poultry products and other articles entering or at official establishments; examination and other requirements.

(a) No poultry product (including poultry broth for use in any poultry product in any official establishment) may be brought into any official establishment unless it has been processed in the United States only in an official establishment or imported from a foreign country listed in § 381.196(b), and inspected and passed, in accordance with the regulations; and unless the container of such product is marked so as to identify the product as so inspected and passed, in accordance with § 381.115 or § 381.205, except that poultry products inspected and passed and identified as such under the laws of an "at least equal" State or territory listed in § 381.187 may be brought into any official establishment solely for storage and distribution therefrom without repackaging, relabeling, or processing in such establishment. No carcass, part thereof, meat or meat food product of cattle, sheep, swine, goats, or equines may be brought into an official establishment unless it has been prepared in the United States only in an official meat packing establishment, or imported, and inspected and passed, in accordance with the Federal Meat Inspection Act, and the regulations under such Act (Subchapter A of this chapter) and is properly marked as so inspected and passed; or has been inspected and passed and is identified as such in accordance with the requirements of the law and regulations of a State not designated in § 331.2 of this chapter; or is present in the official establishment by reason of an exemption allowed in the Federal Meat Inspection Act and the regulations under such Act (Subchapter A of this chapter) or the law and regulations of a State not so designated. However, such exempted articles may enter only under conditions approved by the Administrator in specific cases, including but not limited to, complete separation of inspected poultry products and processing and other operations with respect thereto from the exempted articles and operations with respect thereto, complete cleanup of facilities and equipment between processing of inspected poultry products and the exempted articles and no commingling of inspected and exempted articles in receiving, holding or storage areas.

(b) All poultry products and all carcasses, parts thereof, meat and meat food products of cattle, sheep, swine, goats, or equines which enter any official establishment shall be identified by the operator of the official establishment at the time of receipt at the official establishment. All poultry products, and all carcasses, parts thereof, meat and meat food products of such animals, which are processed or otherwise handled at any official establishment shall be subject to examination by an inspector at the official establishment in such manner and at such times as may be deemed necessary by the inspector in charge to assure compliance with the regulations. Upon such examination, if any such article or portion thereof is found to be adulterated, such article or portion shall, in the case of poultry products, be condemned and disposed of as prescribed in § 381.95, unless by reprocessing they may be made not adulterated, and shall, in the case of such other articles be disposed of according to applicable law. Such examination may be accomplished through use of statistically sound sampling plans that assure a high level of confidence.



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